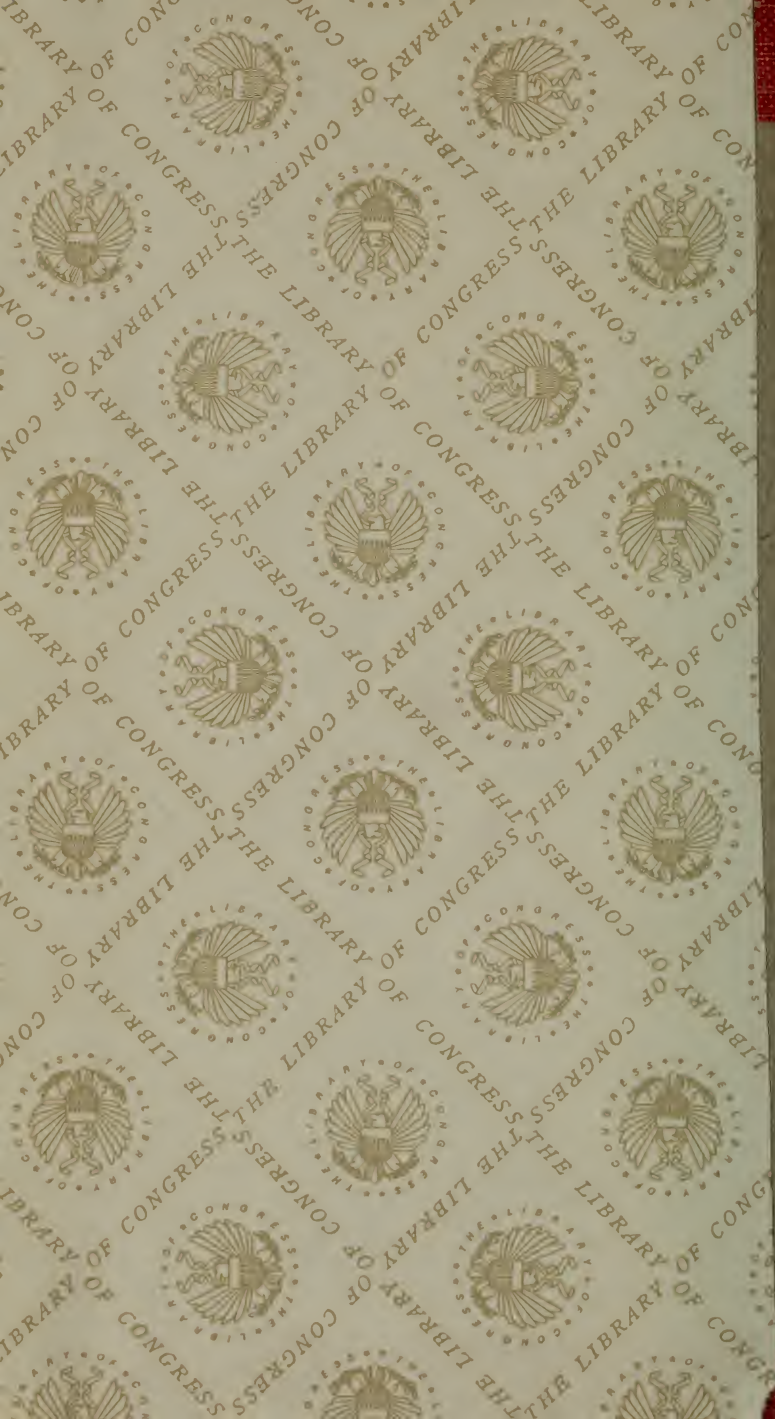
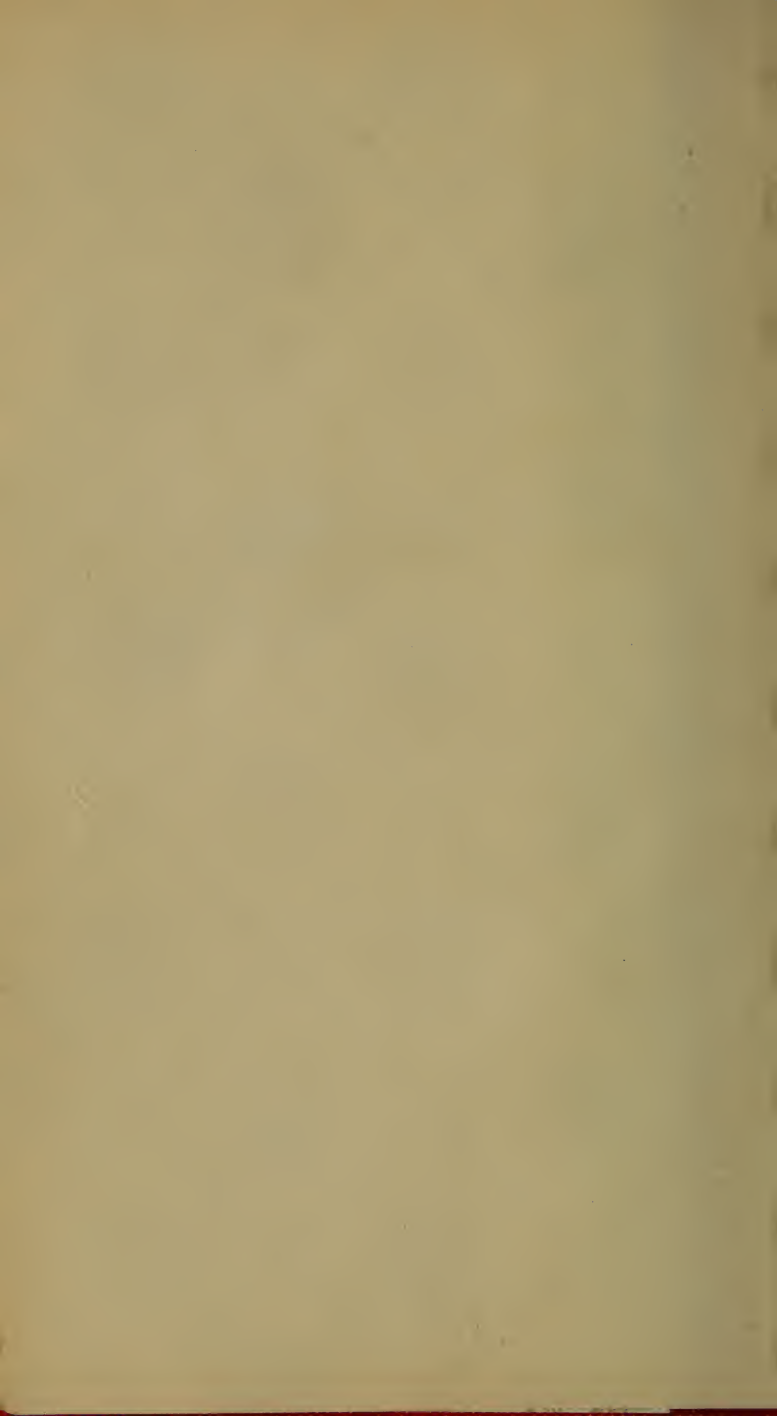


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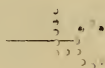
PRICE \$5.00

Piece Work
Rate-Setting Table

FOR

SEVEN, EIGHT, NINE
and TEN HOUR DAY

COMPILED *by* ARCHIBALD L. KLINE
CHICAGO, ILL.



Published and for Sale by
GLENNON & KERN
265 La Salle Street
CHICAGO

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6-2081

INTRODUCTORY

WITHIN the past decade industrial conditions have been completely revolutionized.

The shopman, instead of receiving a given sum per day regardless of what he has actually accomplished, is now remunerated in exact proportion to his personal efforts.

It will no doubt be universally conceded that piece work, the now established fact in almost every large industry in the United States, has very greatly increased the labor of those whose duty it is to keep the records and make the estimates thereof.

This new condition involves the solution of problems of startling intricacy, and are always open to error of more or less costly character. To lessen these labors, to simplify the solution of these problems, and to obviate the possibility of mistake, is the object of this book.

I have used these tables in my own labors in one of America's largest industries, and my years of experience in cost estimating and time-keeping assure me that they will be of assistance to others engaged in a like pursuit.

ARCHIBALD L. KLINE.

Chicago, August, 1905.

EXPLANATORY

These tables are arranged into four main divisions, as follows: Seven, Eight, Nine and Ten hours.

Each of these tables, in turn, are again arranged into sub-divisions of Seconds, Minutes and Hours.

Across the top of the table will be found the wage to be considered. In each of the second tables the wages are arranged so as to run from \$0.75 to \$5.00 per day. There is a gradual rise of \$0.10, excepting that the common rates, such as \$1.25, \$1.75, etc., are given. Between the rate of \$2.75 and the highest rate of \$5.00 the rise is in straight \$0.10 increases.

In the Minute and Hour tables the range is from \$1.50 to \$5.00, in increases of \$0.10, excepting where it is considered advisable to show the common rate, such as \$1.75, \$2.25, etc.

In each of the four main divisions will be found what is called a Piece-Finding Table, arranged for the hour of the division in which it appears, showing the number of pieces when time required to do one piece is more than one minute.

HOW TO USE THE TABLES

In setting rates several preliminary steps are necessary. First, we must make our observations with a stop watch. Five, at least, should be made, each recorded, and from these the average derived.

Let us use, for example, the following: 20 seconds, 18 seconds, 22 seconds, 22 seconds, and 23 seconds, respectively. The total will be 105 seconds. This divided by five (the number of observations) makes the average time required to complete each piece 21 seconds.

Now the actual working day is, for example, nine hours, and it is desired that the employe earn \$2.25 per day. Turn to the nine hour second table, page 40. It takes 21 seconds to complete the piece. Run down the left-hand column until you come to the corresponding time—21 seconds. Then follow across the sheet to the right. In the column to the right of the time column will be found the number of pieces that can be done in one hour at that rate of speed; in the next column the

number of pieces that can be completed in a day of nine hours. Passing on to the twelfth column (the \$2.25 column) you will find the rate to be paid the employee per 100 pieces—\$0.1458 per 100.

In cases where pieces are figured by the thousands all that is necessary is to move the decimal point one point to the right.

EXAMPLE

If the rate paid is \$1.50 per hundred pieces, the rate per 1,000 pieces is \$15.00.

With these examples in mind no trouble will be experienced in figuring the rate for any piece so long as the time for completing the same does not run beyond the limit of that particular table.

In cases where the time required to complete one piece is more than one minute, to find the number of pieces, turn to the finding table for the number of hours worked (page 4).

EXAMPLE

It takes 1 minute and 22 seconds to complete one piece; in 7 hours 307 pieces would be completed.

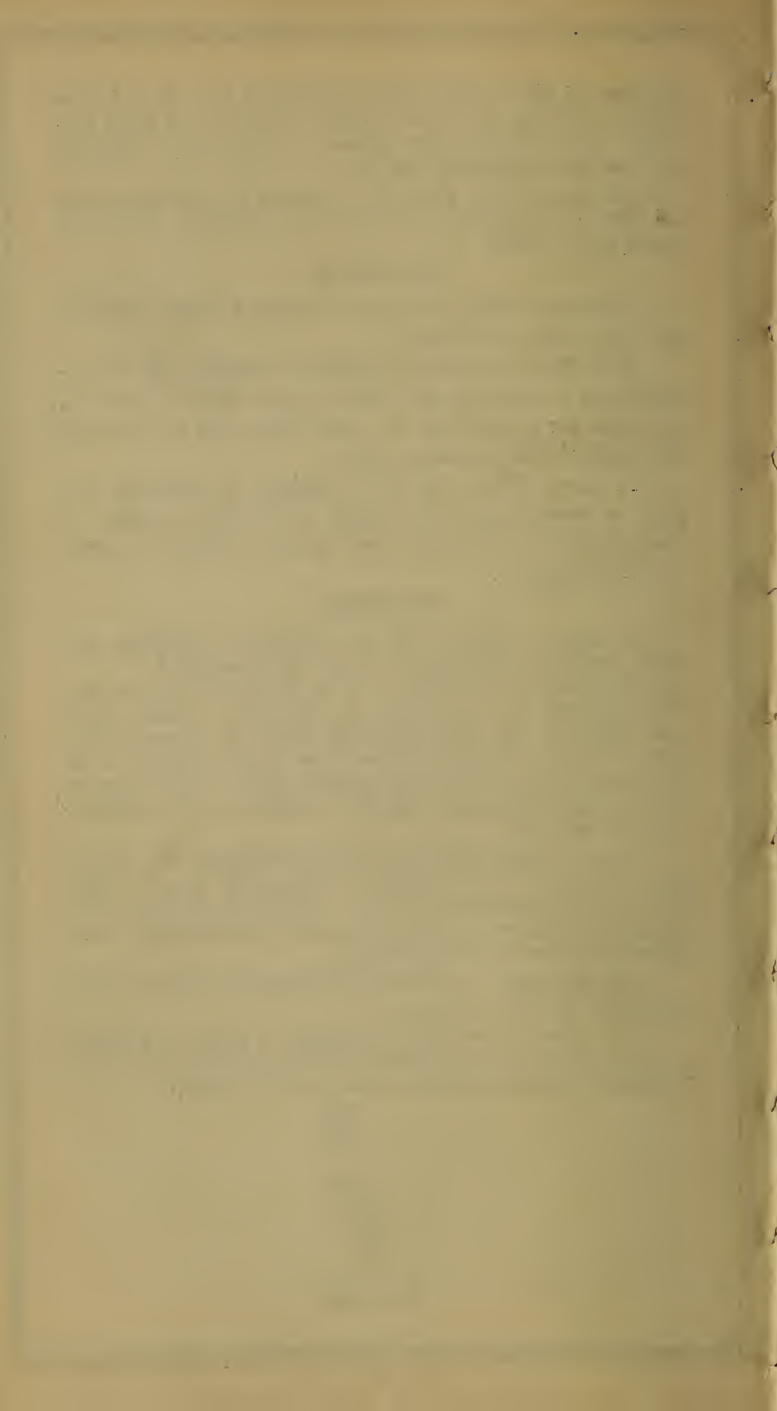
To find the rate per 100 to be paid at \$1.50 per day, turn to page 10, run down the left-hand column until you come to the corresponding time—22 seconds—the rate is .1310. Continue down the same column to 60 seconds, or one minute, the rate is .3571. Add together and you have the piece rate for 1 minute and 22 seconds at \$1.50 per day.

NOTE.—These tables, as will be noticed, are all figured decimally. The object in doing this was to make the amounts absolutely correct; but in the practical use of them it will not require the use of the decimal if the operator prefers to use fractions.

For example: 1458 will be 14 6-10, or 14½, or 14.6; .0923 will be 9¼, or 9.25, etc.

If it takes 21 seconds to complete 1 piece, in 9 hours 1,543 pieces would be completed. At a piece work rate of \$.1458 per 100 the amount earned will be \$2.25.

$$\begin{array}{r}
 1543 \\
 .1458 \\
 \hline
 4374 \\
 5832 \\
 7290 \\
 1458 \\
 \hline
 \$2.249694
 \end{array}$$



PIECE - FINDING TABLE — SEVEN HOURS

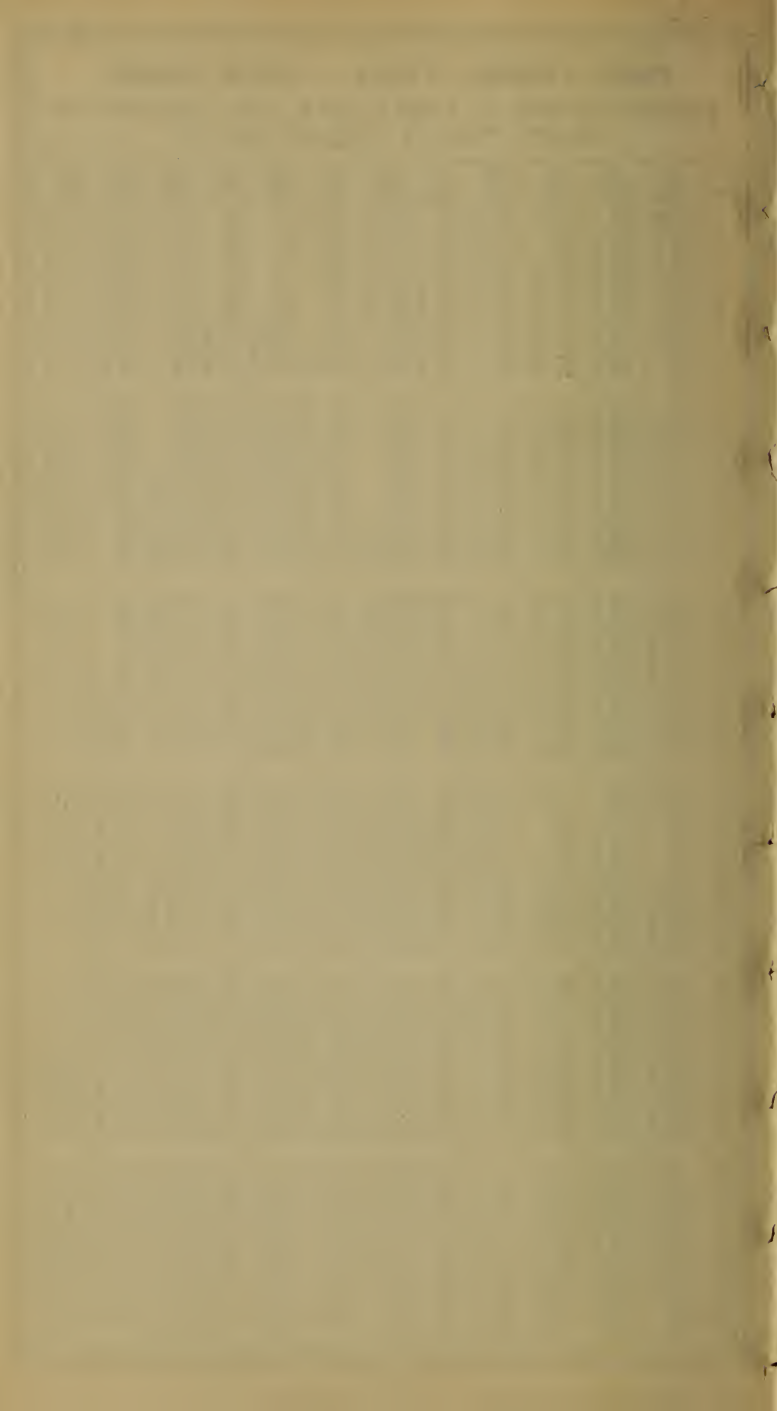
SHOWING NUMBER OF PIECES WHEN TIME REQUIRED TO
DO ONE PIECE IS OVER ONE MINUTE

Sec.	1 Min.	2 Min.	3 Min.	4 Min.	5 Min.	6 Min.	7 Min.	8 Min.	9 Min.	10 Min.	11 Min.	12 Min.
1	420	210	140	105	84	70	60	52.5	46.7	42	38.2	35
2	413	209	139	104.6	83.7	69.8	59.9	52.4	46.6	41.9	38.1	34.9
3	406	207	139	104.3	83.5	69.7	59.8	52.3	46.5	41.9	38.1	34.9
4	400	205	138	103.9	83.2	69.5	59.7	52.2	46.4	41.8	38	34.9
5	394	203	137	103.6	83	69.3	59.6	52.1	46.3	41.7	37.9	34.8
6	388	202	136	103.3	82.8	69.2	59.4	52	46.3	41.7	37.9	34.8
7	382	200	136	102.9	82.5	69	59.3	51.9	46.2	41.6	37.9	34.7
8	376	193	135	102.6	82.3	68.8	59.2	51.8	46.1	41.5	37.8	34.7
9	371	197	134	102.2	82.1	68.6	59.1	51.7	46	41.5	37.8	34.6
10	365	196	134	101.9	81.8	68.5	58.9	51.6	45.9	41.4	37.7	34.6
11	360	194	133	101.6	81.6	68.3	58.8	51.5	45.9	41.4	37.7	34.5
12	355	193	132	101.2	81.3	68.1	58.7	51.4	45.8	41.3	37.6	34.5
13	350	191	131	100.8	81.1	68	58.5	51.3	45.7	41.2	37.5	34.5
14	345	190	131	100.4	80.9	67.8	58.4	51.2	45.6	41.2	37.5	34.4
15	341	188	130	100.1	80.6	67.6	58.3	51.1	45.5	41.1	37.4	34.4
16	336	187	129	99.8	80.4	67.5	58.2	51	45.5	41	37.4	34.3
17	332	186	129	99.4	80.2	67.3	58	50.9	45.4	41	37.3	34.3
18	327	184	128	99.1	79.9	67.1	57.9	50.8	45.3	40.9	37.3	34.2
19	323	183	127	98.7	79.7	66.9	57.8	50.7	45.2	40.8	37.2	34.2
20	319	182	127	98.4	79.5	66.8	57.7	50.6	45.1	40.8	37.2	34.1
21	315	180	126	98.1	79.2	66.7	57.5	50.5	45	40.7	37.1	34.1
22	311	179	125	97.7	79	66.5	57.4	50.4	45	40.6	37.1	34
23	307	178	125	97.4	78.7	66.4	57.3	50.3	44.9	40.6	37	34
24	304	177	124	97	78.5	66.2	57.1	50.2	44.8	40.5	37	34
25	300	175	124	96.7	78.3	66	57	50.1	44.7	40.5	36.9	33.9
26	296	174	123	96.4	78	65.9	56.9	50	44.6	40.4	36.8	33.8
27	293	173	123	96	77.8	65.7	56.8	49.9	44.6	40.3	36.8	33.8
28	290	172	122	95.7	77.6	65.5	56.6	49.8	44.5	40.3	36.7	33.7
29	287	171	121	95.3	77.3	65.3	56.5	49.7	44.4	40.2	36.7	33.7
30	283	170	121	95	77.1	65.2	56.4	49.6	44.3	40.1	36.6	33.7
31	280	168	120	94.7	76.9	65	56.3	49.5	44.2	40.1	36.6	33.6
32	277	167	120	94.3	76.6	64.8	56.1	49.4	44.2	40	36.5	33.6
33	274	166	119	94	76.4	64.7	56	49.3	44.1	40	36.5	33.5
34	271	165	118	93.7	76.1	64.5	55.9	49.2	44	39.9	36.4	33.5
35	268	164	118	93.3	75.9	64.3	55.7	49.1	43.9	39.8	36.4	33.4
36	266	163	117	93	75.7	64.2	55.6	49	43.8	39.7	36.3	33.4
37	263	162	117	92.6	75.4	64	55.5	48.9	43.8	39.7	36.2	33.3
38	260	161	116	92.3	75.2	63.8	55.4	48.8	43.7	39.6	36.2	33.3
39	257	160	116	92	75	63.6	55.2	48.7	43.6	39.6	36.1	33.2
40	255	159	115	91.6	74.7	63.5	55.1	48.6	43.5	39.5	36.1	33.2
41	252	158	115	91.3	74.5	63.3	55	48.5	43.4	39.4	36	33.1
42	250	157	114	90.9	74.3	63.1	54.9	48.4	43.3	39.4	36	33.1
43	247	156	114	90.6	74	63	54.7	48.3	43.3	39.3	35.9	33.1
44	245	155	113	90.3	73.8	62.8	54.6	48.2	43.2	39.2	35.9	33
45	242	154	113	89.9	73.6	62.6	54.5	48.1	43.1	39.2	35.8	33
46	240	153	112	89.6	73.3	62.5	54.3	48	43	39.1	35.7	33
47	238	152	112	89.2	73.1	62.3	54.2	47.9	42.9	39	35.7	32.9
48	236	151	111	88.9	72.8	62.1	54.1	47.8	42.9	39	35.6	32.8
49	234	150	111	88.6	72.6	62	54	47.7	42.8	38.9	35.6	32.8
50	231	149	111	88.2	72.4	61.8	53.8	47.6	42.7	38.8	35.5	32.7
51	229	149	110	87.9	72.1	61.6	53.7	47.5	42.6	38.8	35.5	32.7
52	227	148	109	87.5	71.9	61.5	53.6	47.4	42.5	38.7	35.4	32.6
53	225	147	109	87.2	71.7	61.3	53.5	47.3	42.5	38.7	35.4	32.6
54	223	146	108	86.9	71.4	61.1	53.3	47.2	42.4	38.6	35.3	32.6
55	221	145	108	86.5	71.2	60.9	53.2	47.1	42.3	38.5	35.3	32.5
56	219	144	107	86.2	71	60.8	53.1	47	42.2	38.5	35.2	32.5
57	217	143	107	85.8	70.7	60.6	52.9	46.9	42.1	38.4	35.2	32.4
58	215	142	106	85.5	70.5	60.4	52.8	46.8	42.1	38.3	35.1	32.4
59	213	142	106	85.3	70.2	60.3	52.7	46.7	42	38.3	35.1	32.3
60	212	141	105	85.3	70	60	52.6	46.7	42	38.2	35.1	32.3

PIECE-FINDING TABLE — SEVEN HOURS

SHOWING NUMBER OF PIECES WHEN TIME REQUIRED TO
DO ONE PIECE IS OVER ONE MINUTE

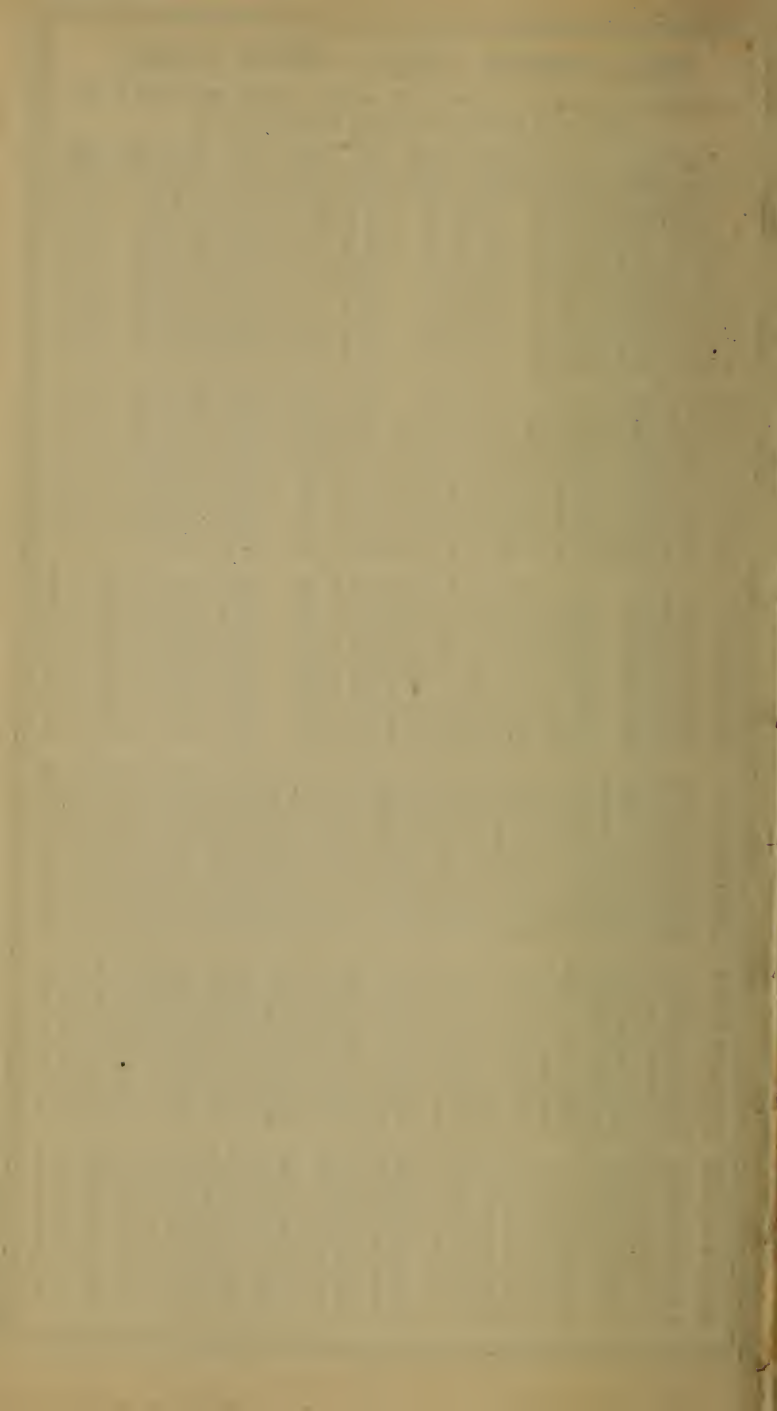
Sec.	13 Min.	14 Min.	15 Min.	16 Min.	17 Min.	18 Min.	19 Min.	20 Min.	21 Min.	22 Min.	23 Min.	24 Min.
1	32.3	30	28	26.2	24.7	23.3	22.1	21	20	19.1	18.3	17.5
2	32.3	30	28	26.2	24.7	23.3	22.1	21	20	19.1	18.3	17.4
3	32.2	29.9	28	26.2	24.7	23.2	22.1	21	20	19.1	18.3	17.4
4	32.2	29.9	27.9	26.2	24.7	23.2	22	21	20	19.1	18.3	17.4
5	32.2	29.9	27.9	26.1	24.6	23.2	22	21	20	19.1	18.2	17.4
6	32.1	29.8	27.9	26.1	24.6	23.2	22	21	20	19.1	18.2	17.4
7	32.1	29.8	27.8	26.1	24.6	23.2	22	20.9	19.9	19.1	18.2	17.4
8	32.1	29.8	27.8	26.1	24.6	23.1	22	20.9	19.9	19	18.2	17.4
9	32	29.8	27.8	26	24.5	23.1	21.9	20.9	19.9	19	18.2	17.4
	32	29.7	27.7	26	24.5	23.1	21.9	20.9	19.9	19	18.2	17.3
10	32	29.7	27.7	26	24.5	23.1	21.9	20.9	19.9	19	18.2	17.3
11	31.9	29.7	27.7	26	24.5	23.1	21.9	20.9	19.9	19	18.1	17.3
12	31.9	29.6	27.6	25.9	24.4	23	21.9	20.8	19.9	19	18.1	17.3
13	31.9	29.6	27.6	25.9	24.4	23	21.9	20.8	19.8	19	18.1	17.3
14	31.8	29.6	27.6	25.9	24.4	23	21.8	20.8	19.8	18.9	18.1	17.3
15	31.8	29.5	27.5	25.9	24.4	23	21.8	20.8	19.8	18.9	18.1	17.3
16	31.7	29.5	27.5	25.8	24.3	23	21.8	20.8	19.8	18.9	18.1	17.3
17	31.7	29.5	27.5	25.8	24.3	22.9	21.8	20.8	19.8	18.9	18.1	17.3
18	31.6	29.4	27.4	25.8	24.3	22.9	21.8	20.7	19.8	18.9	18	17.2
19	31.6	29.4	27.4	25.8	24.3	22.9	21.7	20.7	19.8	18.9	18	17.2
20	31.6	29.4	27.4	25.7	24.2	22.9	21.7	20.7	19.7	18.9	18	17.2
21	31.5	29.3	27.3	25.7	24.2	22.9	21.7	20.7	19.7	18.8	18	17.2
22	31.5	29.3	27.3	25.7	24.2	22.8	21.7	20.7	19.7	18.8	18	17.2
23	31.5	29.3	27.3	25.7	24.2	22.8	21.7	20.7	19.7	18.8	18	17.2
24	31.4	29.2	27.2	25.6	24.1	22.8	21.7	20.6	19.7	18.8	18	17.2
25	31.4	29.2	27.2	25.6	24.1	22.8	21.6	20.6	19.7	18.8	17.9	17.2
26	31.3	29.2	27.2	25.6	24.1	22.8	21.6	20.6	19.6	18.8	17.9	17.2
27	31.3	29.1	27.1	25.6	24.1	22.7	21.6	20.6	19.6	18.8	17.9	17.1
28	31.3	29.1	27.1	25.5	24	22.7	21.6	20.6	19.6	18.7	17.9	17.1
29	31.2	29.1	27.1	25.5	24	22.7	21.6	20.6	19.6	18.7	17.9	17.1
30	31.2	29	27.1	25.5	24	22.7	21.5	20.5	19.6	18.7	17.9	17.1
31	31.1	29	27	25.5	24	22.7	21.5	20.5	19.6	18.7	17.9	17.1
32	31.1	29	27	25.4	23.9	22.6	21.5	20.5	19.5	18.7	17.8	17.1
33	31	28.9	27	25.4	23.9	22.6	21.5	20.5	19.5	18.7	17.8	17.1
34	31	28.9	27	25.4	23.9	22.6	21.5	20.5	19.5	18.7	17.8	17.1
35	31	28.9	26.9	25.4	23.9	22.6	21.5	20.5	19.5	18.6	17.8	17.1
36	30.9	28.8	26.9	25.3	23.8	22.6	21.4	20.4	19.5	18.6	17.8	17
37	30.9	28.8	26.9	25.3	23.8	22.5	21.4	20.4	19.5	18.6	17.8	17
38	30.8	28.8	26.8	25.3	23.8	22.5	21.4	20.4	19.5	18.6	17.8	17
39	30.8	28.7	26.8	25.3	23.8	22.5	21.4	20.4	19.4	18.6	17.7	17
40	30.7	28.7	26.8	25.2	23.7	22.5	21.4	20.4	19.4	18.6	17.7	17
41	30.7	28.7	26.7	25.2	23.7	22.5	21.3	20.4	19.4	18.6	17.7	17
42	30.7	28.6	26.7	25.2	23.7	22.4	21.3	20.3	19.4	18.5	17.7	17
43	30.6	28.6	26.7	25.2	23.7	22.4	21.3	20.3	19.4	18.5	17.7	17
44	30.6	28.6	26.6	25.1	23.6	22.4	21.3	20.3	19.4	18.5	17.7	17
45	30.6	28.5	26.6	25.1	23.6	22.4	21.3	20.3	19.4	18.5	17.7	16.9
46	30.5	28.5	26.6	25.1	23.6	22.4	21.3	20.3	19.3	18.5	17.6	16.9
47	30.5	28.5	26.5	25.1	23.6	22.3	21.2	20.3	19.3	18.5	17.6	16.9
48	30.4	28.4	26.5	25	23.5	22.3	21.2	20.2	19.3	18.5	17.6	16.9
49	30.4	28.4	26.5	25	23.5	22.3	21.2	20.2	19.3	18.4	17.6	16.9
50	30.4	28.4	26.4	25	23.5	22.3	21.2	20.2	19.3	18.4	17.6	16.9
51	30.3	28.3	26.4	25	23.5	22.3	21.2	20.2	19.3	18.4	17.6	16.9
52	30.3	28.3	26.4	24.9	23.4	22.2	21.2	20.2	19.3	18.4	17.6	16.9
53	30.2	28.3	26.3	24.9	23.4	22.2	21.1	20.2	19.2	18.4	17.5	16.9
54	30.2	28.2	26.3	24.9	23.4	22.2	21.1	20.1	19.2	18.4	17.5	16.8
55	30.2	28.2	26.3	24.9	23.4	22.2	21.1	20.1	19.2	18.4	17.5	16.8
56	30.1	28.2	26.3	24.8	23.3	22.2	21.1	20.1	19.2	18.3	17.5	16.8
57	30.1	28.1	26.2	24.8	23.3	22.1	21.1	20.1	19.2	18.3	17.5	16.8
58	30	28.1	26.2	24.8	23.3	22.1	21.1	20.1	19.2	18.3	17.5	16.8
59	30	28.1	26.2	24.8	23.3	22.1	21.1	20.1	19.2	18.3	17.5	16.8



PIECE - FINDING TABLE — SEVEN HOURS

SHOWING NUMBER OF PIECES WHEN TIME REQUIRED TO
DO ONE PIECE IS OVER ONE MINUTE

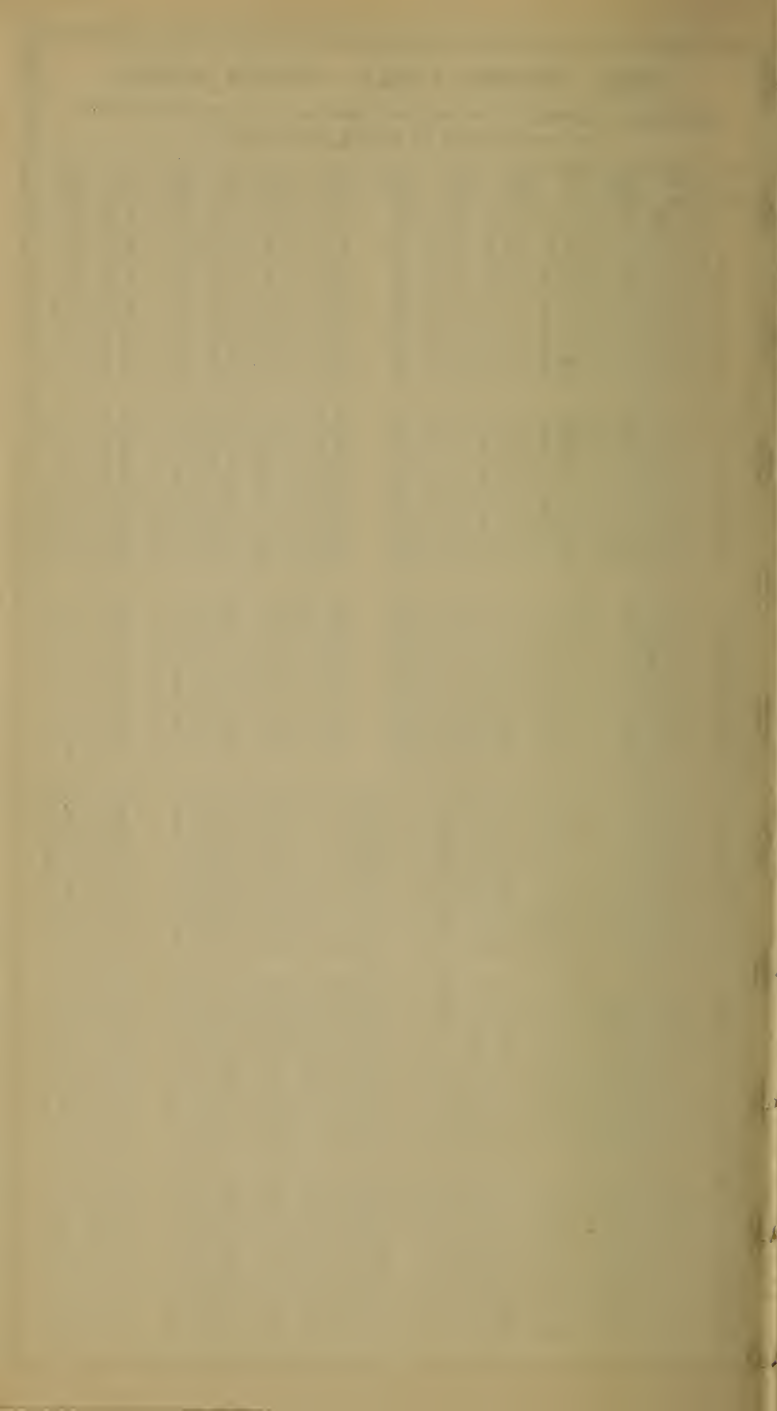
Sec.	25 Min	26 Min.	27 Min.	28 Min.	29 Min.	30 Min	31 Min.	32 Min.	33 Min.	34 Min.	35 Min.	36 Min.
1	16.8	16.2	15.6	15	14.5	14	13.5	13.1	12.7	12.4	12	11.7
2	16.8	16.2	15.6	15	14.5	14	13.5	13.1	12.7	12.4	12	11.7
3	16.8	16.2	15.6	15	14.5	14	13.5	13.1	12.7	12.4	12	11.7
4	16.8	16.2	15.6	15	14.5	14	13.5	13.1	12.7	12.4	12	11.7
5	16.7	16.2	15.6	15	14.5	14	13.5	13.1	12.7	12.4	12	11.7
6	16.7	16.2	15.6	15	14.5	14	13.5	13.1	12.7	12.4	12	11.7
7	16.7	16.2	15.6	15	14.5	14	13.5	13.1	12.7	12.4	12	11.7
8	16.7	16.2	15.6	15	14.5	14	13.5	13.1	12.7	12.4	12	11.7
9	16.7	16.2	15.6	15	14.5	14	13.5	13.1	12.7	12.4	12	11.7
10	16.7	16.1	15.5	15	14.5	14	13.5	13.1	12.7	12.4	12	11.7
11	16.7	16.1	15.5	15	14.5	14	13.5	13.1	12.7	12.4	12	11.7
12	16.7	16.1	15.5	14.9	14.4	13.9	13.5	13.1	12.7	12.4	12	11.7
13	16.7	16.1	15.5	14.9	14.4	13.9	13.5	13.1	12.7	12.4	12	11.7
14	16.7	16.1	15.5	14.9	14.4	13.9	13.5	13.1	12.7	12.4	12	11.7
15	16.7	16.1	15.5	14.9	14.4	13.9	13.4	13	12.7	12.3	12	11.7
16	16.6	16.1	15.5	14.9	14.4	13.9	13.4	13	12.7	12.3	12	11.7
17	16.6	16.1	15.5	14.9	14.4	13.9	13.4	13	12.7	12.3	12	11.7
18	16.6	16.1	15.5	14.9	14.4	13.9	13.4	13	12.7	12.3	12	11.7
19	16.6	16.1	15.5	14.9	14.4	13.9	13.4	13	12.7	12.3	12	11.7
20	16.6	16	15.4	14.9	14.4	13.9	13.4	13	12.6	12.3	11.9	11.6
21	16.6	16	15.4	14.9	14.4	13.9	13.4	13	12.6	12.3	11.9	11.6
22	16.6	16	15.4	14.9	14.4	13.9	13.4	13	12.6	12.3	11.9	11.6
23	16.6	16	15.4	14.9	14.4	13.9	13.4	13	12.6	12.3	11.9	11.6
24	16.6	16	15.4	14.8	14.3	13.8	13.4	13	12.6	12.3	11.9	11.6
25	16.6	16	15.4	14.8	14.3	13.8	13.4	13	12.6	12.3	11.9	11.6
26	16.6	16	15.4	14.8	14.3	13.8	13.4	13	12.6	12.3	11.9	11.6
27	16.5	16	15.4	14.8	14.3	13.8	13.4	13	12.6	12.3	11.9	11.6
28	16.5	16	15.4	14.8	14.3	13.8	13.4	13	12.6	12.3	11.9	11.6
29	16.5	16	15.4	14.8	14.3	13.8	13.4	13	12.6	12.3	11.9	11.6
30	16.5	15.9	15.3	14.8	14.3	13.8	13.3	12.9	12.6	12.2	11.9	11.6
31	16.5	15.9	15.3	14.8	14.3	13.8	13.3	12.9	12.6	12.2	11.9	11.6
32	16.5	15.9	15.3	14.8	14.3	13.8	13.3	12.9	12.6	12.2	11.9	11.6
33	16.5	15.9	15.3	14.8	14.3	13.8	13.3	12.9	12.6	12.2	11.9	11.6
34	16.5	15.9	15.3	14.8	14.3	13.8	13.3	12.9	12.6	12.2	11.9	11.6
35	16.5	15.9	15.3	14.8	14.3	13.8	13.3	12.9	12.6	12.2	11.9	11.6
36	16.5	15.9	15.3	14.7	14.2	13.7	13.3	12.9	12.6	12.2	11.9	11.6
37	16.5	15.9	15.3	14.7	14.2	13.7	13.3	12.9	12.6	12.2	11.9	11.6
38	16.5	15.9	15.3	14.7	14.2	13.7	13.3	12.9	12.6	12.2	11.9	11.6
39	16.4	15.9	15.3	14.7	14.2	13.7	13.3	12.9	12.6	12.2	11.9	11.6
40	16.4	15.8	15.2	14.7	14.2	13.7	13.3	12.9	12.5	12.2	11.8	11.5
41	16.4	15.8	15.2	14.7	14.2	13.7	13.3	12.9	12.5	12.2	11.8	11.5
42	16.4	15.8	15.2	14.7	14.2	13.7	13.3	12.9	12.5	12.2	11.8	11.5
43	16.4	15.8	15.2	14.7	14.2	13.7	13.3	12.9	12.5	12.2	11.8	11.5
44	16.4	15.8	15.2	14.7	14.2	13.7	13.3	12.9	12.5	12.2	11.8	11.5
45	16.4	15.8	15.2	14.7	14.2	13.7	13.2	12.8	12.5	12.1	11.8	11.5
46	16.4	15.8	15.2	14.7	14.2	13.7	13.2	12.8	12.5	12.1	11.8	11.5
47	16.4	15.8	15.2	14.7	14.2	13.7	13.2	12.8	12.5	12.1	11.8	11.5
48	16.4	15.8	15.2	14.6	14.1	13.6	13.2	12.8	12.5	12.1	11.8	11.5
49	16.4	15.8	15.2	14.6	14.1	13.6	13.2	12.8	12.5	12.1	11.8	11.5
50	16.3	15.7	15.1	14.6	14.1	13.6	13.2	12.8	12.5	12.1	11.8	11.5
51	16.3	15.7	15.1	14.6	14.1	13.6	13.2	12.8	12.5	12.1	11.8	11.5
52	16.3	15.7	15.1	14.6	14.1	13.6	13.2	12.8	12.5	12.1	11.8	11.5
53	16.3	15.7	15.1	14.6	14.1	13.6	13.2	12.8	12.5	12.1	11.8	11.5
54	16.3	15.7	15.1	14.6	14.1	13.6	13.2	12.8	12.5	12.1	11.8	11.5
55	16.3	15.7	15.1	14.6	14.1	13.6	13.2	12.8	12.5	12.1	11.8	11.5
56	16.3	15.7	15.1	14.6	14.1	13.6	13.2	12.8	12.5	12.1	11.8	11.5
57	16.3	15.7	15.1	14.6	14.1	13.6	13.2	12.8	12.5	12.1	11.8	11.5
58	16.3	15.7	15.1	14.6	14.1	13.6	13.2	12.8	12.5	12.1	11.8	11.5
59	16.3	15.7	15.1	14.6	14.1	13.6	13.2	12.8	12.5	12.1	11.8	11.5



PIECE-FINDING TABLE — SEVEN HOURS

SHOWING NUMBER OF PIECES WHEN TIME REQUIRED TO
DO ONE PIECE IS OVER ONE MINUTE

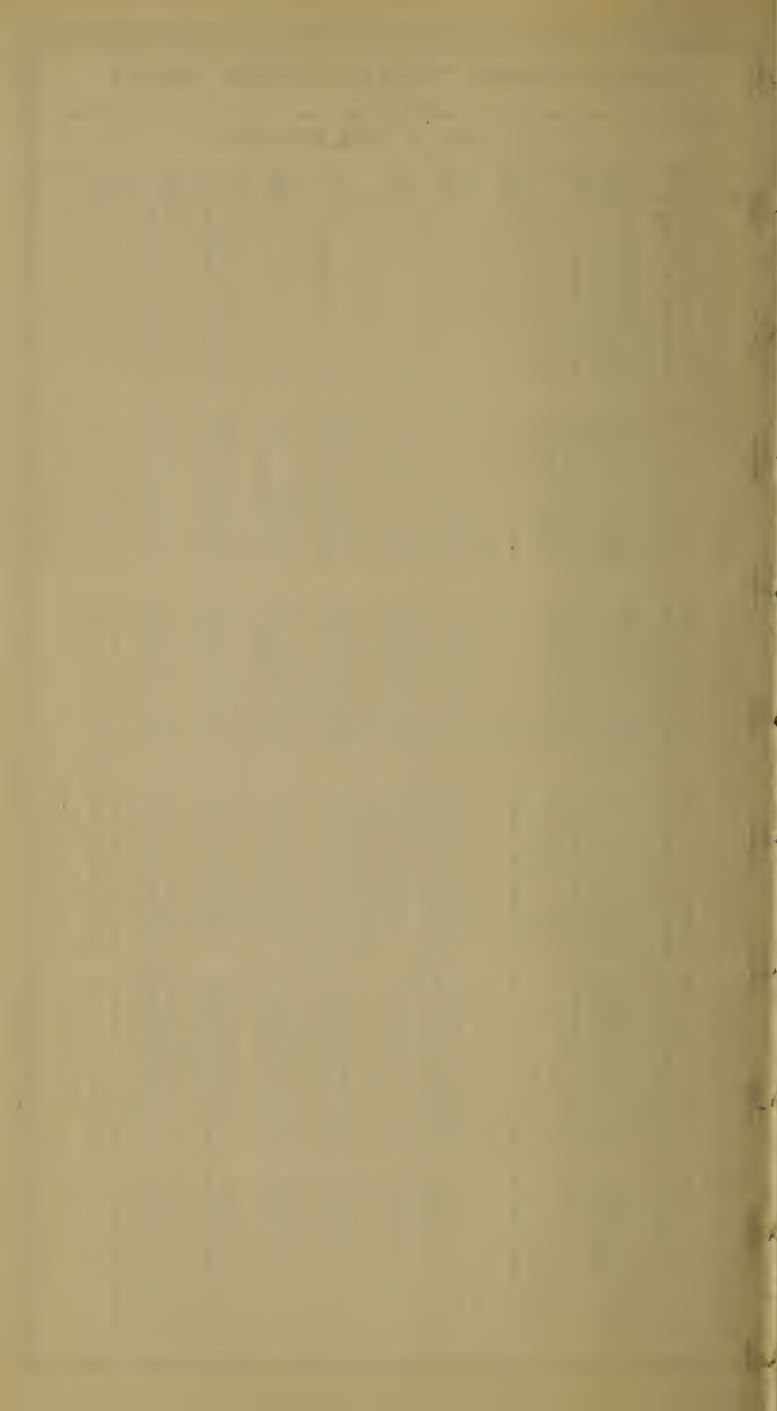
Sec.	37 Min.	38 Min.	39 Min.	40 Min.	41 Min.	42 Min.	43 Min.	44 Min.	45 Min.	46 Min.	47 Min.	48 Min.
1	11.4	11.1	10.8	10.5	10.2	10	9.8	9.5	9.3	9.1	8.9	8.7
2	11.4	11.1	10.8	10.5	10.2	10	9.8	9.5	9.3	9.1	8.9	8.7
3	11.4	11.1	10.8	10.5	10.2	10	9.8	9.5	9.3	9.1	8.9	8.7
4	11.4	11.1	10.8	10.5	10.2	10	9.8	9.5	9.3	9.1	8.9	8.7
5	11.4	11.1	10.8	10.5	10.2	10	9.8	9.5	9.3	9.1	8.9	8.7
6	11.4	11.1	10.8	10.5	10.2	10	9.8	9.5	9.3	9.1	8.9	8.7
7	11.4	11.1	10.8	10.5	10.2	10	9.8	9.5	9.3	9.1	8.9	8.7
8	11.4	11.1	10.8	10.5	10.2	10	9.8	9.5	9.3	9.1	8.9	8.7
9	11.4	11.1	10.8	10.5	10.2	10	9.8	9.5	9.3	9.1	8.9	8.7
10	11.4	11.1	10.8	10.5	10.2	10	9.8	9.5	9.3	9.1	8.9	8.7
11	11.4	11.1	10.8	10.5	10.2	10	9.8	9.5	9.3	9.1	8.9	8.7
12	11.4	11.1	10.8	10.5	10.2	10	9.8	9.5	9.3	9.1	8.9	8.7
13	11.4	11.1	10.8	10.5	10.2	10	9.8	9.5	9.3	9.1	8.9	8.7
14	11.4	11.1	10.8	10.5	10.2	10	9.8	9.5	9.3	9.1	8.9	8.7
15	11.4	11.1	10.8	10.5	10.2	10	9.8	9.5	9.3	9.1	8.9	8.7
16	11.4	11.1	10.8	10.5	10.2	10	9.8	9.5	9.3	9.1	8.9	8.7
17	11.4	11.1	10.8	10.5	10.2	10	9.8	9.5	9.3	9.1	8.9	8.7
18	11.4	11.1	10.8	10.5	10.2	10	9.8	9.5	9.3	9.1	8.9	8.7
19	11.4	11.1	10.8	10.5	10.2	10	9.8	9.5	9.3	9.1	8.9	8.7
20	11.3	11	10.7	10.4	10.2	10	9.7	9.5	9.3	9.1	8.9	8.7
21	11.3	11	10.7	10.4	10.2	10	9.7	9.5	9.3	9.1	8.9	8.7
22	11.3	11	10.7	10.4	10.2	10	9.7	9.5	9.3	9.1	8.9	8.7
23	11.3	11	10.7	10.4	10.2	10	9.7	9.5	9.3	9.1	8.9	8.7
24	11.3	11	10.7	10.4	10.2	10	9.7	9.5	9.3	9.1	8.9	8.7
25	11.3	11	10.7	10.4	10.2	10	9.7	9.5	9.3	9.1	8.9	8.7
26	11.3	11	10.7	10.4	10.2	10	9.7	9.5	9.3	9.1	8.9	8.7
27	11.3	11	10.7	10.4	10.2	10	9.7	9.5	9.3	9.1	8.9	8.7
28	11.3	11	10.7	10.4	10.2	10	9.7	9.5	9.3	9.1	8.9	8.7
29	11.3	11	10.7	10.4	10.2	10	9.7	9.5	9.3	9.1	8.9	8.7
30	11.3	11	10.7	10.4	10.1	9.9	9.7	9.4	9.2	9	8.8	8.6
31	11.3	11	10.7	10.4	10.1	9.9	9.7	9.4	9.2	9	8.8	8.6
32	11.3	11	10.7	10.4	10.1	9.9	9.7	9.4	9.2	9	8.8	8.6
33	11.3	11	10.7	10.4	10.1	9.9	9.7	9.4	9.2	9	8.8	8.6
34	11.3	11	10.7	10.4	10.1	9.9	9.7	9.4	9.2	9	8.8	8.6
35	11.3	11	10.7	10.4	10.1	9.9	9.7	9.4	9.2	9	8.8	8.6
36	11.3	11	10.7	10.4	10.1	9.9	9.7	9.4	9.2	9	8.8	8.6
37	11.3	11	10.7	10.4	10.1	9.9	9.7	9.4	9.2	9	8.8	8.6
38	11.3	11	10.7	10.4	10.1	9.9	9.7	9.4	9.2	9	8.8	8.6
39	11.3	11	10.7	10.4	10.1	9.9	9.7	9.4	9.2	9	8.8	8.6
40	11.2	11	10.7	10.4	10.1	9.9	9.7	9.4	9.2	9	8.8	8.6
41	11.2	10.9	10.6	10.3	10.1	9.9	9.6	9.4	9.2	9	8.8	8.6
42	11.2	10.9	10.6	10.3	10.1	9.9	9.6	9.4	9.2	9	8.8	8.6
43	11.2	10.9	10.6	10.3	10.1	9.9	9.6	9.4	9.2	9	8.8	8.6
44	11.2	10.9	10.6	10.3	10.1	9.9	9.6	9.4	9.2	9	8.8	8.6
45	11.2	10.9	10.6	10.3	10.1	9.9	9.6	9.4	9.2	9	8.8	8.6
46	11.2	10.9	10.6	10.3	10.1	9.9	9.6	9.4	9.2	9	8.8	8.6
47	11.2	10.9	10.6	10.3	10.1	9.9	9.6	9.4	9.2	9	8.8	8.6
48	11.2	10.9	10.6	10.3	10.1	9.9	9.6	9.4	9.2	9	8.8	8.6
49	11.2	10.9	10.6	10.3	10.1	9.9	9.6	9.4	9.2	9	8.8	8.6
50	11.2	10.9	10.6	10.3	10.1	9.9	9.6	9.4	9.2	9	8.8	8.6
51	11.2	10.9	10.6	10.3	10.1	9.9	9.6	9.4	9.2	9	8.8	8.6
52	11.2	10.9	10.6	10.3	10.1	9.9	9.6	9.4	9.2	9	8.8	8.6
53	11.2	10.9	10.6	10.3	10.1	9.9	9.6	9.4	9.2	9	8.8	8.6
54	11.2	10.9	10.6	10.3	10.1	9.9	9.6	9.4	9.2	9	8.8	8.6
55	11.2	10.9	10.6	10.3	10.1	9.9	9.6	9.4	9.2	9	8.8	8.6
56	11.2	10.9	10.6	10.3	10.1	9.9	9.6	9.4	9.2	9	8.8	8.6
57	11.2	10.9	10.6	10.3	10.1	9.9	9.6	9.4	9.2	9	8.8	8.6
58	11.2	10.9	10.6	10.3	10.1	9.9	9.6	9.4	9.2	9	8.8	8.6
59	11.2	10.9	10.6	10.3	10.1	9.9	9.6	9.4	9.2	9	8.8	8.6



PIECE-FINDING TABLE — SEVEN HOURS

SHOWING NUMBER OF PIECES WHEN TIME REQUIRED TO
DO ONE PIECE IS OVER ONE MINUTE

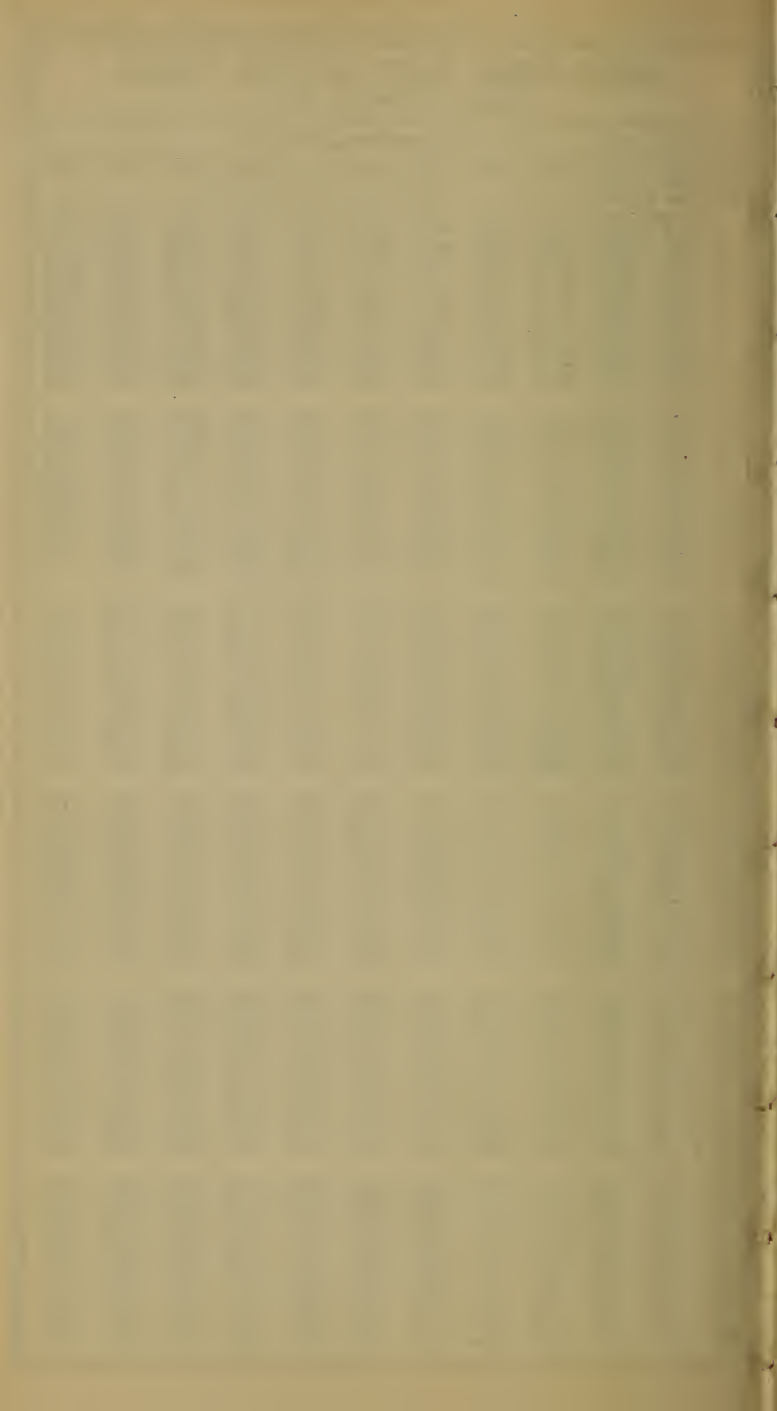
Sec.	49 Min.	50 Min.	51 Min.	52 Min.	53 Min.	54 Min.	55 Min.	56 Min.	57 Min.	58 Min.	59 Min.
1	8.5	8.4	8.2	8.1	7.9	7.8	7.6	7.5	7.4	7.3	7.1
2	8.5	8.3	8.2	8.1	7.9	7.8	7.6	7.5	7.4	7.3	7.1
3	8.5	8.3	8.2	8.1	7.9	7.8	7.6	7.5	7.4	7.3	7.1
4	8.5	8.3	8.2	8.1	7.9	7.8	7.6	7.5	7.4	7.3	7.1
5	8.5	8.3	8.2	8.1	7.9	7.8	7.6	7.5	7.4	7.3	7.1
6	8.5	8.3	8.2	8.1	7.9	7.8	7.6	7.5	7.4	7.3	7.1
7	8.5	8.3	8.2	8.1	7.9	7.8	7.6	7.5	7.4	7.3	7.1
8	8.5	8.3	8.2	8.1	7.9	7.8	7.6	7.5	7.4	7.3	7.1
9	8.5	8.3	8.2	8.1	7.9	7.8	7.6	7.5	7.4	7.3	7.1
10	8.5	8.3	8.2	8.1	7.9	7.8	7.6	7.5	7.4	7.3	7.1
11	8.5	8.3	8.2	8.1	7.9	7.8	7.6	7.5	7.4	7.3	7.1
12	8.5	8.3	8.2	8.1	7.9	7.8	7.6	7.5	7.4	7.3	7.1
13	8.5	8.3	8.2	8.1	7.9	7.8	7.6	7.5	7.4	7.3	7.1
14	8.5	8.3	8.2	8.1	7.9	7.8	7.6	7.5	7.4	7.3	7.1
15	8.5	8.3	8.2	8.1	7.9	7.8	7.6	7.5	7.4	7.3	7.1
16	8.5	8.3	8.2	8.1	7.9	7.8	7.6	7.5	7.4	7.3	7.1
17	8.5	8.3	8.2	8.1	7.9	7.8	7.6	7.5	7.4	7.3	7.1
18	8.5	8.3	8.2	8.1	7.9	7.8	7.6	7.5	7.4	7.3	7.1
19	8.5	8.3	8.2	8.1	7.9	7.8	7.6	7.5	7.4	7.3	7.1
20	8.5	8.3	8.2	8.1	7.9	7.8	7.6	7.5	7.4	7.2	7.1
21	8.5	8.3	8.2	8.1	7.9	7.8	7.6	7.5	7.4	7.2	7.1
22	8.5	8.3	8.2	8.1	7.9	7.8	7.6	7.5	7.4	7.2	7.1
23	8.5	8.3	8.2	8.1	7.9	7.8	7.6	7.5	7.4	7.2	7.1
24	8.5	8.3	8.2	8.1	7.9	7.8	7.6	7.5	7.4	7.2	7.1
25	8.5	8.3	8.2	8.1	7.9	7.8	7.6	7.5	7.4	7.2	7.1
26	8.5	8.3	8.2	8.1	7.9	7.8	7.6	7.5	7.4	7.2	7.1
27	8.5	8.3	8.2	8.1	7.9	7.8	7.6	7.5	7.4	7.2	7.1
28	8.5	8.3	8.2	8.1	7.9	7.8	7.6	7.5	7.4	7.2	7.1
29	8.5	8.3	8.2	8.1	7.9	7.8	7.6	7.5	7.4	7.2	7.1
30	8.4	8.3	8.2	8	7.9	7.8	7.6	7.5	7.3	7.2	7.1
31	8.4	8.3	8.2	8	7.8	7.8	7.6	7.5	7.3	7.2	7.1
32	8.4	8.3	8.2	8	7.8	7.8	7.6	7.5	7.3	7.2	7.1
33	8.4	8.3	8.2	8	7.8	7.8	7.6	7.5	7.3	7.2	7.1
34	8.4	8.3	8.2	8	7.8	7.8	7.6	7.5	7.3	7.2	7.1
35	8.4	8.3	8.1	8	7.8	7.8	7.6	7.5	7.3	7.2	7.1
36	8.4	8.3	8.1	8	7.8	7.8	7.6	7.5	7.3	7.2	7.1
37	8.4	8.3	8.1	8	7.8	7.8	7.6	7.5	7.3	7.2	7.1
38	8.4	8.3	8.1	8	7.8	7.8	7.6	7.5	7.3	7.2	7.1
39	8.4	8.3	8.1	8	7.8	7.7	7.6	7.5	7.3	7.2	7.1
40	8.4	8.3	8.1	8	7.8	7.7	7.5	7.4	7.3	7.2	7.1
41	8.4	8.3	8.1	8	7.8	7.7	7.5	7.4	7.3	7.2	7.1
42	8.4	8.3	8.1	8	7.8	7.7	7.5	7.4	7.3	7.2	7.1
43	8.4	8.3	8.1	8	7.8	7.7	7.5	7.4	7.3	7.2	7.1
44	8.4	8.3	8.1	8	7.8	7.7	7.5	7.4	7.3	7.2	7.1
45	8.4	8.3	8.1	8	7.8	7.7	7.5	7.4	7.3	7.2	7.1
46	8.4	8.3	8.1	8	7.8	7.7	7.5	7.4	7.3	7.2	7.1
47	8.4	8.3	8.1	8	7.8	7.7	7.5	7.4	7.3	7.2	7.1
48	8.4	8.3	8.1	8	7.8	7.7	7.5	7.4	7.3	7.2	7.1
49	8.4	8.3	8.1	8	7.8	7.7	7.5	7.4	7.3	7.2	7.1
50	8.4	8.3	8.1	8	7.8	7.7	7.5	7.4	7.3	7.2	7
51	8.4	8.3	8.1	8	7.8	7.7	7.5	7.4	7.3	7.2	7
52	8.4	8.3	8.1	8	7.8	7.7	7.5	7.4	7.3	7.2	7
53	8.4	8.3	8.1	8	7.8	7.7	7.5	7.4	7.3	7.2	7
54	8.4	8.3	8.1	8	7.8	7.7	7.5	7.4	7.3	7.2	7
55	8.4	8.2	8.1	8	7.8	7.7	7.5	7.4	7.3	7.2	7
56	8.4	8.2	8.1	8	7.8	7.7	7.5	7.4	7.3	7.2	7
57	8.4	8.2	8.1	8	7.8	7.7	7.5	7.4	7.3	7.2	7
58	8.4	8.2	8.1	8	7.8	7.7	7.5	7.4	7.3	7.2	7
59	8.4	8.2	8.1	8	7.8	7.7	7.5	7.4	7.3	7.2	7



PIECE WORK RATE-SETTING TABLE

SEVEN HOURS A DAY

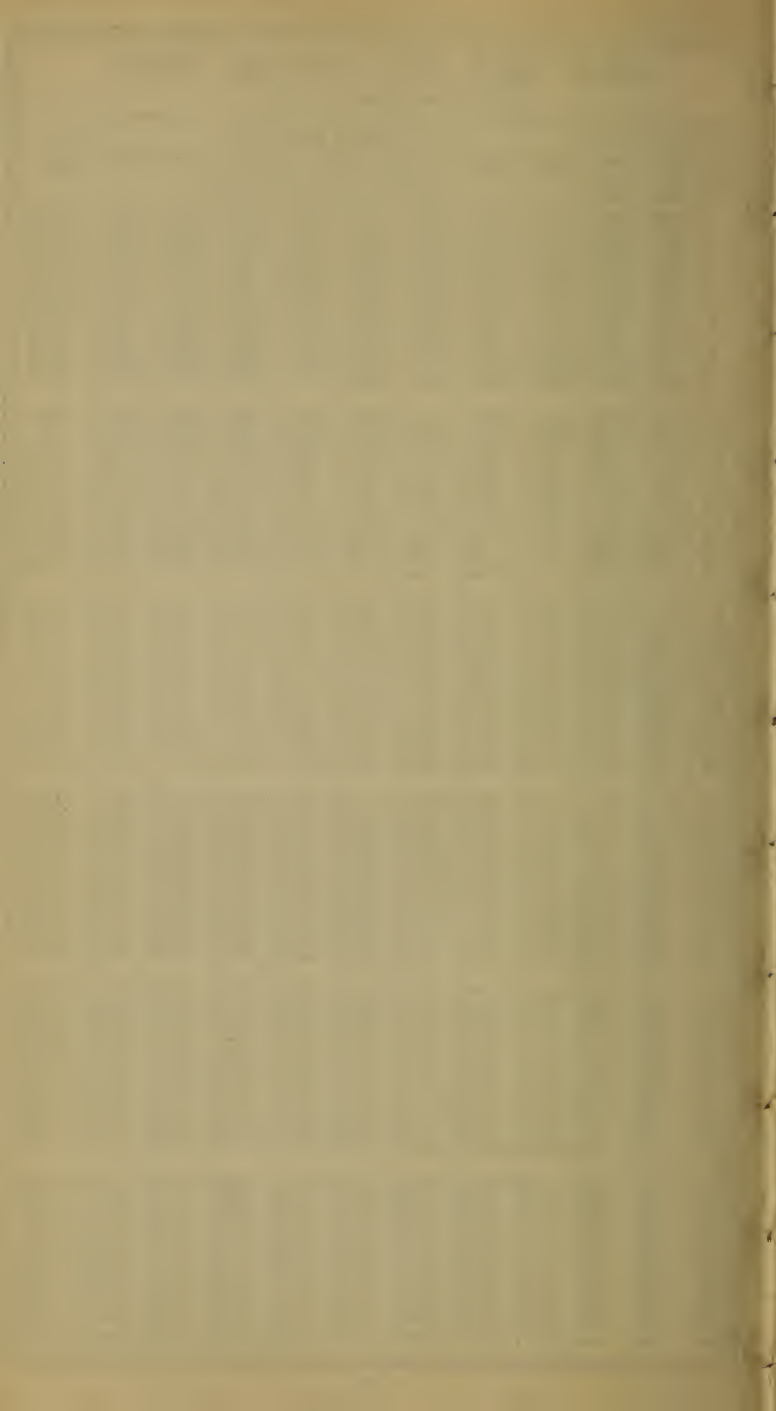
Sec. to do One Piece	No. of Pieces in One Hour	No. of Pieces in Seven Hours	AMOUNT PER DAY								
			.75	.80	.90	1.00	1.10	1.20	1.25	1.30	1.40
			RATE PER 100 PIECES								
1	3600	25200	.0030	.0032	.0036	.0040	.0044	.0048	.0050	.0052	.0056
2	1800	12600	.0060	.0063	.0071	.0079	.0087	.0095	.0099	.0104	.0111
3	1200	8400	.0089	.0095	.0107	.0119	.0131	.0143	.0149	.0156	.0167
4	930	6300	.0119	.0127	.0143	.0159	.0175	.0191	.0198	.0207	.0222
5	720	5040	.0148	.0159	.0179	.0198	.0218	.0238	.0248	.0259	.0278
6	600	4200	.0178	.0190	.0214	.0238	.0262	.0286	.0298	.0311	.0333
7	514	3500	.0208	.0222	.0250	.0278	.0306	.0333	.0347	.0362	.0389
8	450	3150	.0238	.0254	.0286	.0317	.0349	.0381	.0397	.0414	.0444
9	400	2800	.0268	.0285	.0321	.0357	.0393	.0429	.0446	.0465	.0500
10	360	2520	.0297	.0317	.0357	.0397	.0437	.0476	.0496	.0517	.0556
11	327	2291	.0327	.0349	.0393	.0437	.0480	.0524	.0546	.0568	.0611
12	300	2100	.0357	.0380	.0429	.0476	.0524	.0572	.0595	.0620	.0667
13	277	1938	.0387	.0412	.0464	.0516	.0567	.0619	.0645	.0672	.0722
14	257	1800	.0416	.0444	.0500	.0556	.0611	.0667	.0694	.0723	.0778
15	240	1680	.0446	.0476	.0536	.0595	.0655	.0714	.0744	.0775	.0833
16	225	1575	.0476	.0507	.0571	.0635	.0698	.0762	.0794	.0826	.0889
17	212	1483	.0505	.0539	.0607	.0675	.0743	.0810	.0843	.0877	.0944
18	200	1400	.0535	.0570	.0643	.0714	.0786	.0857	.0893	.0929	.1000
19	190	1326	.0565	.0603	.0679	.0754	.0829	.0905	.0942	.0980	.1056
20	180	1260	.0595	.0634	.0714	.0794	.0873	.0953	.0992	.1032	.1111
21	171	1200	.0625	.0667	.0750	.0833	.0917	.1000	.1042	.1083	.1167
22	164	1145	.0655	.0698	.0786	.0873	.0960	.1048	.1091	.1135	.1222
23	157	1096	.0684	.0730	.0821	.0913	.1004	.1095	.1141	.1187	.1278
24	150	1050	.0714	.0762	.0857	.0952	.1048	.1143	.1190	.1238	.1333
25	144	1008	.0744	.0794	.0893	.0992	.1091	.1191	.1240	.1290	.1389
26	138	959	.0774	.0825	.0929	.1032	.1135	.1238	.1290	.1341	.1444
27	133	933	.0804	.0857	.0964	.1071	.1179	.1286	.1339	.1393	.1500
28	129	900	.0833	.0889	.1000	.1111	.1222	.1334	.1389	.1444	.1556
29	124	869	.0863	.0921	.1036	.1151	.1266	.1381	.1438	.1496	.1621
30	120	840	.0894	.0952	.1071	.1190	.1310	.1429	.1488	.1547	.1667
31	116	813	.0923	.0984	.1107	.1230	.1353	.1476	.1538	.1599	.1722
32	112	787	.0953	.1016	.1143	.1270	.1397	.1524	.1587	.1650	.1778
33	109	764	.0982	.1048	.1179	.1310	.1440	.1572	.1637	.1702	.1833
34	106	741	.1012	.1079	.1214	.1349	.1484	.1619	.1687	.1754	.1889
35	103	720	.1042	.1111	.1250	.1389	.1528	.1667	.1738	.1805	.1944
36	100	700	.1071	.1143	.1286	.1429	.1571	.1714	.1786	.1857	.2000
37	97	681	.1101	.1175	.1321	.1468	.1615	.1762	.1835	.1908	.2056
38	95	663	.1131	.1206	.1357	.1508	.1659	.1810	.1885	.1960	.2111
39	92	646	.1161	.1238	.1393	.1548	.1702	.1857	.1935	.2011	.2167
40	90	630	.1190	.1270	.1429	.1587	.1746	.1905	.1984	.2063	.2222
41	88	615	.1220	.1302	.1464	.1627	.1790	.1952	.2034	.2115	.2278
42	86	600	.1250	.1333	.1500	.1667	.1833	.2000	.2083	.2166	.2333
43	84	586	.1280	.1365	.1536	.1706	.1877	.2048	.2133	.2218	.2489
44	82	573	.1309	.1397	.1571	.1746	.1921	.2095	.2183	.2269	.2444
45	80	560	.1340	.1429	.1607	.1786	.1964	.2143	.2232	.2321	.2500
46	78	548	.1369	.1460	.1642	.1825	.2008	.2191	.2282	.2373	.2556
47	76	536	.1400	.1492	.1679	.1865	.2052	.2238	.2331	.2424	.2611
48	75	525	.1429	.1524	.1714	.1905	.2095	.2286	.2381	.2476	.2667
49	73	514	.1459	.1556	.1749	.1944	.2139	.2333	.2431	.2527	.2722
50	72	504	.1488	.1587	.1786	.1985	.2183	.2381	.2480	.2579	.2778
51	71	494	.1518	.1619	.1821	.2024	.2226	.2429	.2530	.2631	.2833
52	69	485	.1546	.1651	.1857	.2064	.2270	.2476	.2579	.2682	.2889
53	68	475	.1579	.1683	.1893	.2103	.2313	.2524	.2629	.2734	.2944
54	67	467	.1606	.1714	.1929	.2143	.2357	.2572	.2679	.2785	.3000
55	65	458	.1635	.1746	.1964	.2183	.2401	.2619	.2728	.2837	.3056
56	64	450	.1667	.1778	.2000	.2222	.2444	.2667	.2778	.2889	.3111
57	63	442	.1697	.1810	.2036	.2262	.2488	.2714	.2827	.2940	.3167
58	62	434	.1728	.1841	.2071	.2302	.2532	.2762	.2877	.2992	.3222
59	61	427	.1756	.1873	.2107	.2341	.2575	.2810	.2927	.3043	.3278
60	60	420	.1786	.1905	.2143	.2381	.2619	.2857	.2976	.3095	.3333



PIECE WORK RATE-SETTING TABLE

SEVEN HOURS A DAY

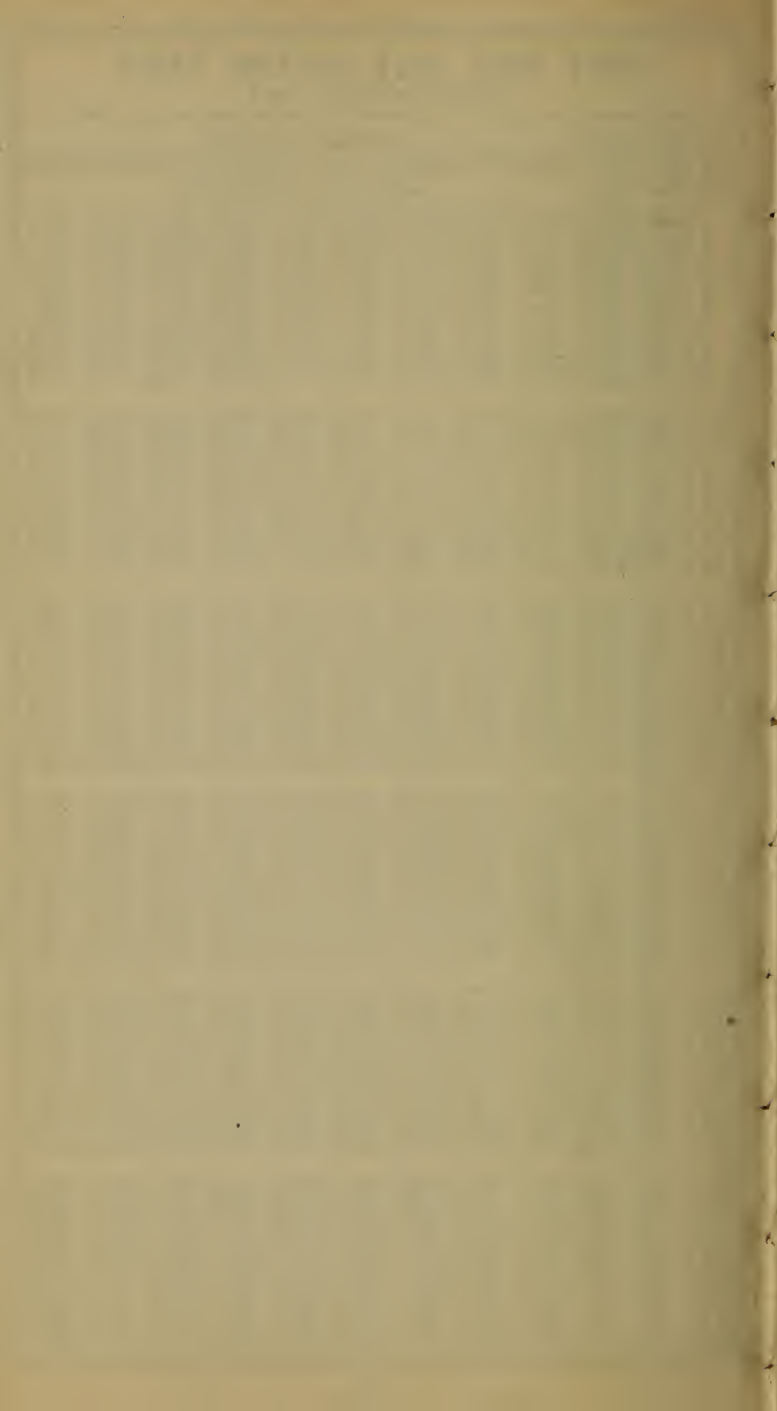
Sec. to do One Piece	No. of Pieces in One Hour	No. of Pieces in Seven Hours	AMOUNT PER DAY								
			1.50	1.60	1.70	1.75	1.80	1.90	2.00	2.10	2.25
			RATE PER 100 PIECES								
1	3600	25200	.0060	.0063	.0067	.0069	.0071	.0075	.0079	.0083	.0089
2	1800	12600	.0119	.0127	.0135	.0139	.0143	.0151	.0159	.0167	.0179
3	1200	8400	.0179	.0190	.0202	.0209	.0214	.0226	.0238	.0250	.0268
4	900	6300	.0238	.0254	.0270	.0278	.0286	.0302	.0317	.0333	.0357
5	720	5040	.0298	.0317	.0337	.0347	.0357	.0377	.0397	.0417	.0446
6	600	4200	.0357	.0381	.0405	.0417	.0429	.0452	.0476	.0500	.0536
7	514	3600	.0417	.0444	.0472	.0486	.0500	.0528	.0556	.0583	.0625
8	450	3150	.0476	.0503	.0540	.0556	.0571	.0603	.0635	.0667	.0714
9	400	2800	.0536	.0571	.0607	.0624	.0642	.0679	.0714	.0750	.0804
10	360	2520	.0595	.0635	.0675	.0694	.0714	.0754	.0794	.0833	.0893
11	327	2291	.0655	.0698	.0742	.0764	.0786	.0829	.0873	.0917	.0982
12	300	2100	.0714	.0761	.0810	.0833	.0857	.0905	.0952	.1000	.1071
13	277	1938	.0774	.0825	.0877	.0903	.0929	.0980	.1032	.1082	.1161
14	257	1800	.0833	.0888	.0944	.0972	.1000	.1056	.1111	.1167	.1250
15	240	1680	.0893	.0952	.1012	.1042	.1071	.1131	.1190	.1250	.1339
16	225	1575	.0952	.1015	.1079	.1111	.1143	.1206	.1270	.1333	.1429
17	212	1483	.1012	.1079	.1147	.1180	.1214	.1282	.1349	.1417	.1518
18	200	1400	.1072	.1142	.1214	.1250	.1286	.1357	.1429	.1500	.1607
19	190	1326	.1131	.1206	.1282	.1319	.1357	.1433	.1508	.1583	.1696
20	180	1260	.1190	.1269	.1349	.1389	.1429	.1508	.1587	.1667	.1786
21	171	1200	.1250	.1333	.1417	.1458	.1500	.1583	.1667	.1750	.1875
22	164	1145	.1310	.1396	.1484	.1528	.1571	.1659	.1746	.1833	.1964
23	157	1096	.1369	.1459	.1552	.1597	.1643	.1734	.1825	.1917	.2054
24	150	1050	.1429	.1524	.1619	.1667	.1714	.1810	.1905	.2000	.2143
25	144	1008	.1488	.1587	.1687	.1736	.1786	.1885	.1984	.2083	.2232
26	138	969	.1548	.1650	.1754	.1805	.1857	.1960	.2063	.2167	.2321
27	133	933	.1607	.1713	.1821	.1875	.1929	.2036	.2143	.2250	.2411
28	129	900	.1667	.1777	.1889	.1944	.2000	.2111	.2222	.2333	.2500
29	124	869	.1726	.1840	.1956	.2014	.2071	.2187	.2302	.2417	.2589
30	120	840	.1786	.1904	.2024	.2083	.2143	.2262	.2381	.2500	.2679
31	116	813	.1845	.1967	.2091	.2153	.2214	.2337	.2460	.2583	.2768
32	112	787	.1905	.2030	.2159	.2222	.2286	.2413	.2540	.2667	.2857
33	109	764	.1964	.2094	.2226	.2292	.2357	.2488	.2619	.2750	.2946
34	106	741	.2024	.2157	.2294	.2361	.2429	.2563	.2698	.2833	.3036
35	103	720	.2083	.2221	.2361	.2420	.2500	.2639	.2778	.2917	.3125
36	100	700	.2143	.2284	.2429	.2490	.2571	.2714	.2857	.3000	.3214
37	97	681	.2202	.2348	.2496	.2559	.2643	.2790	.2937	.3083	.3304
38	95	663	.2262	.2411	.2563	.2629	.2714	.2865	.3016	.3167	.3393
39	92	646	.2321	.2475	.2631	.2698	.2786	.2940	.3095	.3250	.3482
40	90	630	.2381	.2538	.2698	.2768	.2857	.3016	.3175	.3333	.3571
41	88	615	.2440	.2602	.2766	.2837	.2929	.3091	.3254	.3417	.3661
42	86	600	.2500	.2665	.2833	.2907	.3000	.3167	.3333	.3500	.3750
43	84	586	.2560	.2728	.2901	.2976	.3071	.3244	.3413	.3583	.3839
44	82	573	.2619	.2792	.2968	.3045	.3143	.3317	.3492	.3667	.3929
45	80	560	.2679	.2855	.3036	.3115	.3214	.3393	.3571	.3750	.4018
46	78	548	.2738	.2919	.3103	.3184	.3286	.3468	.3651	.3833	.4107
47	76	536	.2797	.2982	.3171	.3254	.3357	.3544	.3730	.3917	.4196
48	75	525	.2857	.3046	.3238	.3323	.3429	.3619	.3810	.4000	.4286
49	73	514	.2917	.3109	.3306	.3393	.3500	.3694	.3889	.4083	.4375
50	72	504	.2976	.3173	.3373	.3462	.3571	.3770	.3968	.4167	.4465
51	71	494	.3036	.3236	.3440	.3532	.3643	.3845	.4048	.4250	.4554
52	69	485	.3095	.3300	.3508	.3601	.3714	.3921	.4127	.4333	.4643
53	68	475	.3155	.3363	.3575	.3670	.3786	.3996	.4206	.4417	.4732
54	67	467	.3214	.3446	.3642	.3740	.3857	.4071	.4286	.4500	.4821
55	65	458	.3274	.3490	.3710	.3809	.3929	.4147	.4365	.4583	.4910
56	64	450	.3333	.3553	.3778	.3879	.4000	.4222	.4444	.4667	.5000
57	63	442	.3393	.3617	.3845	.3948	.4071	.4298	.4524	.4750	.5089
58	62	434	.3452	.3680	.3913	.4018	.4143	.4373	.4603	.4833	.5178
59	61	427	.3512	.3744	.3980	.4087	.4214	.4448	.4683	.4917	.5267
60	60	420	.3571	.3807	.4048	.4157	.4286	.4524	.4762	.5000	.5356



PIECE WORK RATE-SETTING TABLE

SEVEN HOURS A DAY

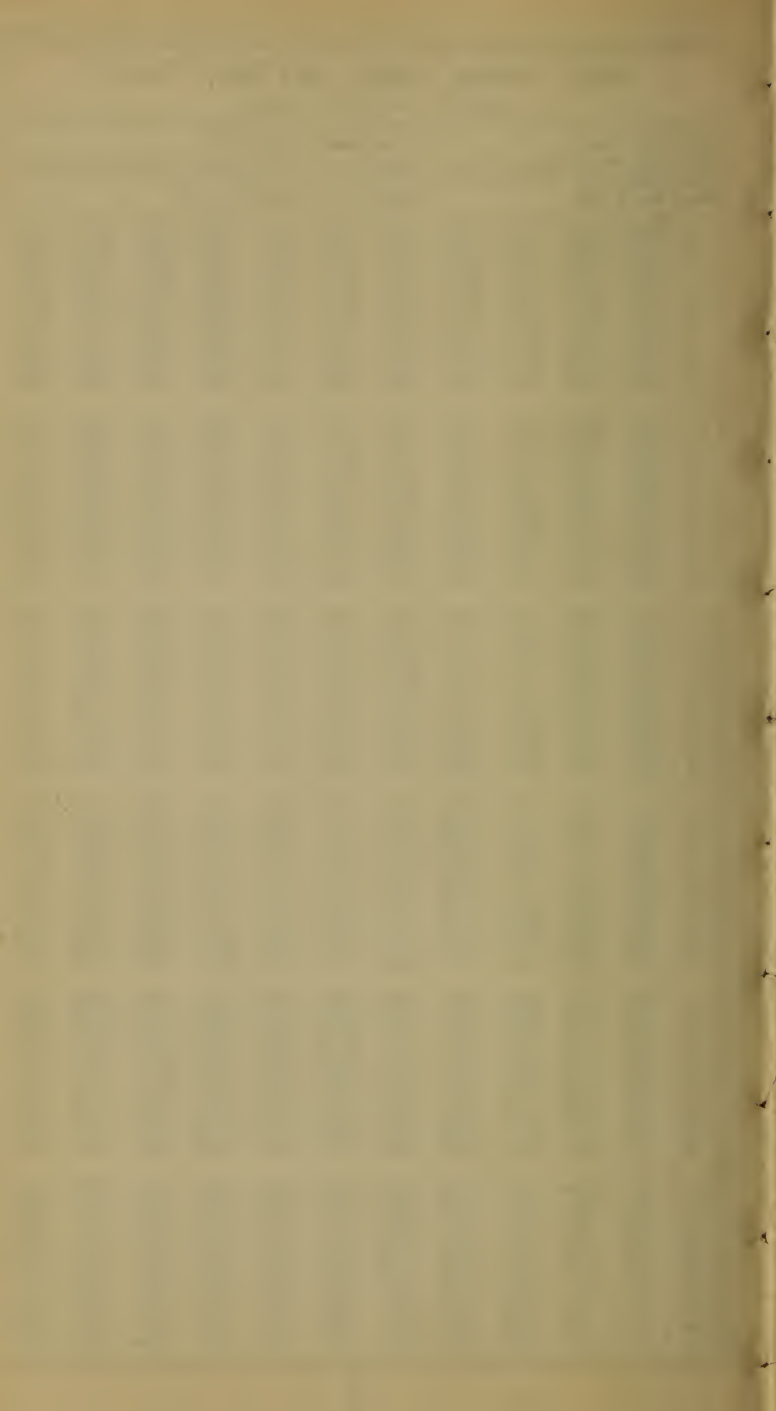
Sec. to do One Piece	No. of Pieces in One Hour	No. of Pieces in Seven Hours	AMOUNT PER DAY								
			2.40	2.50	2.60	2.75	2.80	2.90	3.00	3.10	3.20
RATE PER 100 PIECES											
1	3600	25200	.0095	.0099	.0103	.0109	.0111	.0115	.0119	.0123	.0127
2	1800	12600	.0190	.0198	.0206	.0218	.0222	.0230	.0238	.0246	.0254
3	1200	8400	.0286	.0298	.0310	.0327	.0333	.0345	.0357	.0369	.0381
4	900	6300	.0381	.0397	.0413	.0437	.0444	.0460	.0476	.0492	.0508
5	720	5040	.0476	.0496	.0516	.0546	.0556	.0575	.0595	.0615	.0634
6	600	4200	.0571	.0595	.0619	.0655	.0667	.0690	.0714	.0738	.0761
7	514	3600	.0667	.0694	.0722	.0764	.0778	.0806	.0833	.0861	.0888
8	450	3150	.0762	.0794	.0825	.0823	.0889	.0921	.0952	.0984	.1015
9	400	2800	.0857	.0893	.0929	.0982	.1000	.1036	.1071	.1107	.1142
10	360	2520	.0952	.0992	.1032	.1091	.1111	.1151	.1190	.1230	.1269
11	327	2291	.1048	.1091	.1135	.1200	.1222	.1266	.1310	.1353	.1396
12	300	2100	.1143	.1190	.1238	.1310	.1333	.1381	.1429	.1476	.1523
13	277	1938	.1238	.1290	.1341	.1419	.1444	.1490	.1548	.1599	.1650
14	257	1800	.1333	.1389	.1444	.1528	.1556	.1611	.1667	.1722	.1777
15	240	1680	.1429	.1488	.1548	.1637	.1667	.1720	.1786	.1845	.1903
16	225	1575	.1524	.1587	.1651	.1746	.1778	.1841	.1905	.1968	.2030
17	212	1483	.1619	.1686	.1754	.1855	.1889	.1956	.2024	.2091	.2157
18	200	1400	.1714	.1786	.1857	.1964	.2000	.2071	.2143	.2214	.2284
19	190	1326	.1810	.1885	.1960	.2073	.2111	.2187	.2262	.2337	.2411
20	180	1260	.1905	.1984	.2063	.2183	.2222	.2302	.2382	.2460	.2538
21	171	1200	.2000	.2083	.2167	.2292	.2333	.2417	.2501	.2583	.2665
22	164	1145	.2095	.2182	.2270	.2401	.2444	.2532	.2620	.2706	.2792
23	157	1096	.2191	.2282	.2373	.2510	.2556	.2648	.2739	.2829	.2919
24	150	1050	.2286	.2381	.2476	.2619	.2667	.2763	.2858	.2952	.3046
25	144	1008	.2381	.2480	.2579	.2728	.2778	.2878	.2977	.3075	.3172
26	138	969	.2476	.2579	.2682	.2837	.2889	.2993	.3096	.3198	.3299
27	133	933	.2572	.2678	.2786	.2946	.3000	.3108	.3215	.3321	.3426
28	129	900	.2667	.2778	.2889	.3055	.3111	.3223	.3334	.3444	.3553
29	124	869	.2762	.2877	.2992	.3164	.3222	.3338	.3454	.3567	.3680
30	120	840	.2857	.2976	.3095	.3273	.3333	.3453	.3573	.3690	.3807
31	116	813	.2953	.3075	.3198	.3382	.3444	.3569	.3692	.3813	.3934
32	112	787	.3048	.3174	.3301	.3491	.3556	.3684	.3811	.3936	.4061
33	109	764	.3143	.3274	.3405	.3600	.3667	.3799	.3930	.4059	.4188
34	106	741	.3238	.3373	.3508	.3709	.3778	.3914	.4049	.4182	.4315
35	103	720	.3334	.3472	.3611	.3818	.3889	.4029	.4168	.4305	.4441
36	100	700	.3429	.3571	.3714	.3928	.4000	.4144	.4287	.4428	.4568
37	97	681	.3524	.3670	.3817	.4037	.4111	.4259	.4406	.4551	.4695
38	95	663	.3619	.3770	.3920	.4146	.4222	.4374	.4526	.4674	.4822
39	92	646	.3715	.3869	.4024	.4255	.4333	.4489	.4645	.4797	.4949
40	90	630	.3810	.3968	.4127	.4364	.4444	.4604	.4764	.4920	.5076
41	88	615	.3905	.4067	.4230	.4473	.4556	.4719	.4883	.5043	.5203
42	86	600	.4000	.4166	.4333	.4582	.4667	.4834	.5002	.5166	.5330
43	84	586	.4096	.4266	.4436	.4691	.4778	.4950	.5121	.5289	.5457
44	82	573	.4191	.4365	.4539	.4800	.4889	.5065	.5240	.5412	.5584
45	80	560	.4286	.4464	.4643	.4909	.5000	.5180	.5359	.5535	.5710
46	78	548	.4381	.4563	.4746	.5018	.5111	.5295	.5478	.5658	.5837
47	76	536	.4477	.4663	.4849	.5127	.5222	.5410	.5598	.5781	.5964
48	75	525	.4572	.4762	.4952	.5236	.5333	.5525	.5717	.5904	.6091
49	73	514	.4667	.4861	.5055	.5346	.5444	.5640	.5836	.6027	.6218
50	72	504	.4762	.4960	.5158	.5454	.5556	.5755	.5955	.6150	.6345
51	71	494	.4858	.5059	.5262	.5563	.5667	.5870	.6074	.6273	.6472
52	69	485	.4953	.5158	.5365	.5673	.5778	.5985	.6193	.6396	.6599
53	68	475	.5048	.5258	.5468	.5782	.5889	.6100	.6312	.6519	.6726
54	67	467	.5143	.5357	.5571	.5891	.6000	.6215	.6431	.6642	.6853
55	65	458	.5239	.5456	.5674	.6001	.6111	.6331	.6550	.6765	.6979
56	64	450	.5334	.5555	.5777	.6110	.6222	.6446	.6670	.6888	.7106
57	63	442	.5429	.5654	.5881	.6219	.6333	.6561	.6789	.7011	.7233
58	62	434	.5524	.5754	.5984	.6328	.6444	.6676	.6908	.7134	.7360
59	61	427	.5620	.5853	.6087	.6437	.6556	.6791	.7027	.7257	.7487
60	60	420	.5715	.5952	.6190	.6547	.6667	.6906	.7146	.7381	.7614



PIECE WORK RATE-SETTING TABLE

SEVEN HOURS A DAY

Sec. to do One Piece	No. of Pieces in One Hour	No. of Pieces in Seven Hours	AMOUNT PER DAY								
			3.30	3.40	3.50	3.60	3.70	3.80	3.90	4.00	4.10
			RATE PER 100 PIECES								
1	3600	25200	.0131	.0135	.0139	.0143	.0147	.0151	.0155	.0159	.0163
2	1800	12600	.0262	.0270	.0278	.0286	.0294	.0302	.0310	.0317	.0325
3	1200	8400	.0393	.0405	.0417	.0429	.0440	.0452	.0464	.0476	.0488
4	900	6300	.0524	.0540	.0556	.0571	.0587	.0600	.0619	.0635	.0651
5	720	5040	.0655	.0675	.0694	.0714	.0734	.0754	.0774	.0794	.0813
6	600	4200	.0786	.0810	.0833	.0857	.0881	.0905	.0929	.0952	.0976
7	514	3600	.0917	.0945	.0972	.1000	.1028	.1056	.1083	.1111	.1139
8	450	3150	.1048	.1080	.1111	.1143	.1175	.1206	.1238	.1270	.1302
9	400	2800	.1179	.1215	.1250	.1286	.1321	.1357	.1393	.1429	.1464
10	360	2520	.1310	.1350	.1389	.1429	.1468	.1508	.1548	.1587	.1627
11	327	2291	.1440	.1485	.1528	.1571	.1615	.1659	.1702	.1746	.1790
12	300	2100	.1571	.1620	.1667	.1714	.1762	.1809	.1857	.1905	.1952
13	277	1938	.1702	.1755	.1806	.1857	.1909	.1960	.2012	.2063	.2115
14	257	1800	.1833	.1890	.1944	.2000	.2056	.2110	.2167	.2222	.2278
15	240	1680	.1964	.2025	.2083	.2143	.2202	.2262	.2321	.2381	.2440
16	225	1575	.2095	.2160	.2222	.2286	.2349	.2413	.2476	.2540	.2603
17	212	1483	.2226	.2295	.2361	.2429	.2496	.2563	.2631	.2698	.2766
18	200	1400	.2357	.2430	.2500	.2571	.2643	.2714	.2786	.2857	.2928
19	190	1326	.2488	.2565	.2639	.2714	.2790	.2865	.2940	.3016	.3091
20	180	1260	.2619	.2700	.2778	.2857	.2937	.3016	.3095	.3175	.3254
21	171	1200	.2750	.2835	.2917	.3000	.3083	.3167	.3250	.3333	.3416
22	164	1145	.2881	.2970	.3056	.3143	.3230	.3317	.3405	.3492	.3579
23	157	1096	.3012	.3105	.3194	.3286	.3377	.3468	.3559	.3651	.3742
24	150	1050	.3143	.3240	.3333	.3429	.3524	.3619	.3714	.3810	.3905
25	144	1008	.3274	.3375	.3472	.3571	.3671	.3770	.3869	.3967	.4067
26	138	969	.3405	.3510	.3611	.3714	.3817	.3921	.4024	.4127	.4240
27	133	933	.3536	.3645	.3750	.3857	.3964	.4071	.4179	.4286	.4393
28	129	900	.3667	.3780	.3889	.4000	.4111	.4222	.4333	.4444	.4555
29	124	869	.3798	.3915	.4028	.4143	.4258	.4373	.4488	.4603	.4718
30	120	840	.3929	.4050	.4167	.4286	.4405	.4524	.4643	.4762	.4881
31	116	813	.4060	.4185	.4306	.4429	.4556	.4674	.4798	.4921	.5043
32	112	787	.4190	.4320	.4444	.4571	.4698	.4825	.4952	.5079	.5206
33	109	764	.4321	.4455	.4583	.4714	.4845	.4976	.5107	.5238	.5369
34	106	741	.4452	.4590	.4722	.4857	.4992	.5127	.5262	.5397	.5531
35	103	720	.4583	.4730	.4861	.5000	.5139	.5278	.5417	.5555	.5694
36	100	700	.4714	.4865	.5000	.5143	.5286	.5428	.5571	.5714	.5857
37	97	681	.4845	.5000	.5139	.5286	.5433	.5579	.5726	.5873	.6020
38	95	663	.4976	.5135	.5278	.5429	.5579	.5730	.5881	.6032	.6182
39	92	646	.5107	.5270	.5417	.5571	.5726	.5881	.6036	.6190	.6345
40	90	630	.5238	.5404	.5556	.5714	.5873	.6032	.6190	.6349	.6508
41	88	615	.5369	.5540	.5694	.5857	.6020	.6182	.6345	.6508	.6670
42	86	600	.5500	.5675	.5833	.6000	.6167	.6333	.6500	.6666	.6833
43	84	586	.5631	.5810	.5972	.6143	.6313	.6484	.6655	.6825	.6996
44	82	573	.5762	.5945	.6111	.6286	.6460	.6635	.6809	.6984	.7158
45	80	560	.5893	.6080	.6250	.6429	.6607	.6786	.6964	.7143	.7321
46	78	548	.6024	.6215	.6389	.6571	.6754	.6936	.7119	.7302	.7484
47	76	536	.6155	.6350	.6528	.6714	.6901	.7087	.7274	.7460	.7646
48	75	525	.6286	.6485	.6667	.6857	.7048	.7238	.7428	.7619	.7809
49	73	514	.6417	.6620	.6806	.7000	.7194	.7389	.7583	.7777	.7972
50	72	504	.6548	.6755	.6944	.7143	.7341	.7540	.7738	.7937	.8135
51	71	494	.6679	.6890	.7083	.7286	.7488	.7690	.7893	.8095	.8297
52	69	485	.6810	.7025	.7222	.7429	.7634	.7841	.8048	.8254	.8460
53	68	475	.6940	.7160	.7361	.7571	.7782	.7992	.8202	.8413	.8623
54	67	467	.7071	.7295	.7500	.7714	.7930	.8143	.8357	.8571	.8785
55	65	458	.7202	.7430	.7639	.7857	.8075	.8293	.8512	.8730	.8948
56	64	450	.7333	.7565	.7778	.8000	.8222	.8444	.8667	.8889	.9111
57	63	442	.7464	.7700	.7917	.8143	.8369	.8595	.8821	.9048	.9273
58	62	434	.7595	.7835	.8056	.8286	.8516	.8746	.8976	.9206	.9436
59	61	427	.7726	.7970	.8194	.8429	.8663	.8897	.9131	.9365	.9599
60	60	420	.7857	.8105	.8333	.8571	.8810	.9047	.9286	.9524	.9761



PIECE WORK RATE-SETTING TABLE

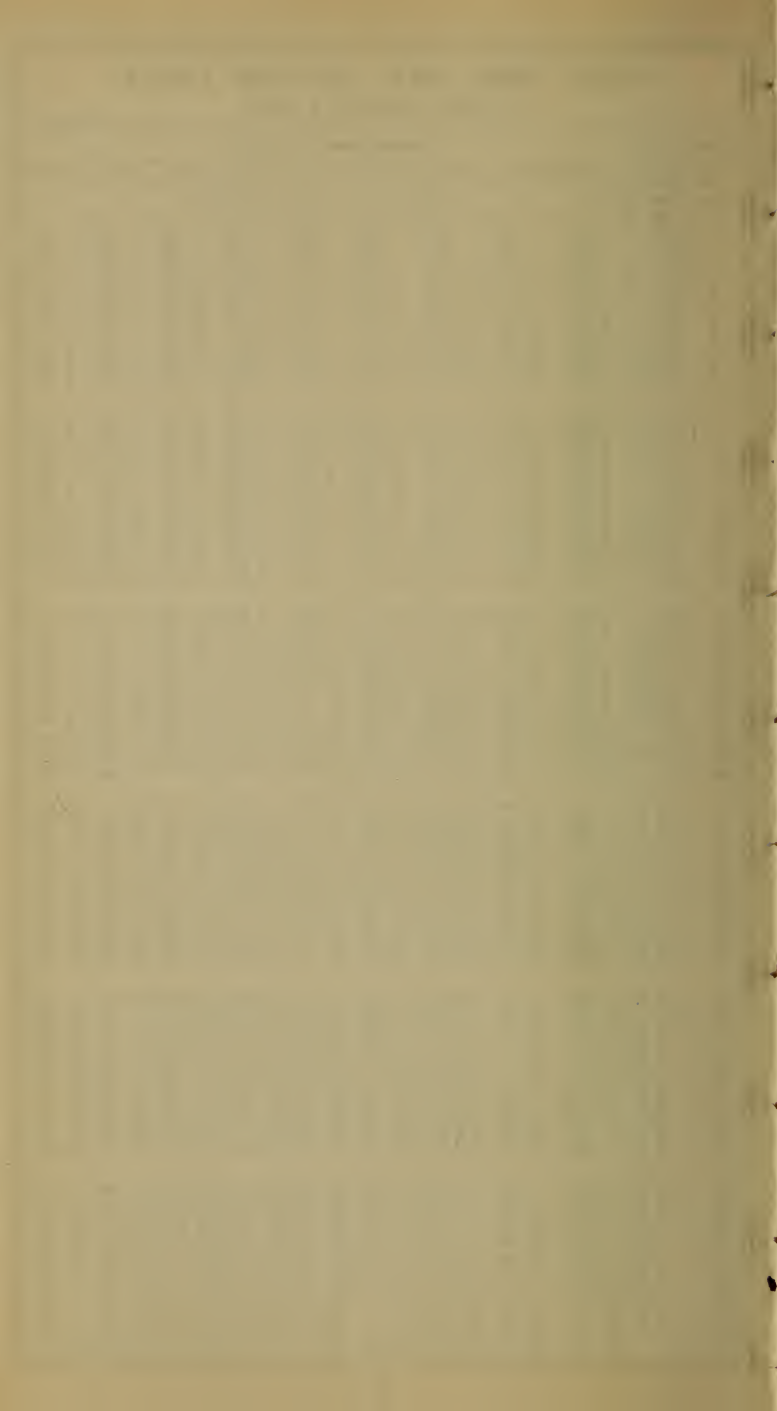
SEVEN HOURS A DAY

Sec. to do One Piece	No. of Pieces In One Hour	No. of Pieces in Seven Hours	AMOUNT PER DAY								
			4.20	4.30	4.40	4.50	4.60	4.70	4.80	4.90	5.00
			RATE PER 100 PIECES								
1	3600	25200	.0167	.0171	.0175	.0179	.0183	.0187	.0190	.0194	.0198
2	1800	12600	.0333	.0341	.0349	.0357	.0365	.0373	.0381	.0389	.0397
3	1200	8400	.0500	.0512	.0524	.0536	.0548	.0560	.0571	.0583	.0595
4	900	6300	.0667	.0683	.0698	.0714	.0730	.0746	.0762	.0778	.0794
5	720	5040	.0833	.0853	.0873	.0893	.0913	.0933	.0952	.0972	.0992
6	600	4200	.1000	.1024	.1048	.1071	.1095	.1119	.1143	.1167	.1190
7	514	3600	.1167	.1194	.1222	.1250	.1278	.1306	.1333	.1361	.1389
8	450	3150	.1333	.1365	.1397	.1428	.1460	.1492	.1524	.1556	.1587
9	400	2800	.1500	.1536	.1571	.1607	.1643	.1679	.1714	.1750	.1786
10	360	2520	.1667	.1701	.1746	.1786	.1825	.1866	.1905	.1944	.1984
11	327	2291	.1833	.1877	.1921	.1964	.2008	.2052	.2095	.2139	.2182
12	300	2100	.2000	.2048	.2095	.2143	.2190	.2239	.2286	.2333	.2381
13	277	1938	.2167	.2218	.2270	.2321	.2373	.2425	.2476	.2528	.2579
14	257	1800	.2333	.2389	.2444	.2510	.2555	.2612	.2667	.2722	.2778
15	240	1680	.2501	.2559	.2619	.2678	.2738	.2798	.2857	.2917	.2976
16	225	1575	.2667	.2730	.2794	.2857	.2920	.2985	.3048	.3111	.3174
17	212	1483	.2833	.2901	.2968	.3036	.3103	.3172	.3238	.3305	.3373
18	200	1400	.3000	.3071	.3143	.3214	.3286	.3358	.3428	.3500	.3571
19	190	1326	.3167	.3242	.3317	.3393	.3468	.3545	.3619	.3694	.3770
20	180	1260	.3333	.3413	.3492	.3571	.3651	.3731	.3809	.3889	.3968
21	171	1200	.3500	.3583	.3666	.3750	.3833	.3918	.4000	.4083	.4166
22	164	1145	.3667	.3754	.3841	.3928	.4016	.4104	.4190	.4278	.4365
23	157	1096	.3833	.3924	.4006	.4107	.4198	.4219	.4381	.4472	.4563
24	150	1050	.4000	.4095	.4180	.4285	.4381	.4477	.4571	.4667	.4762
25	144	1008	.4167	.4266	.4355	.4464	.4563	.4664	.4762	.4861	.4960
26	138	969	.4333	.4436	.4530	.4643	.4746	.4851	.4952	.5055	.5158
27	133	933	.4500	.4607	.4704	.4821	.4928	.5037	.5143	.5250	.5357
28	129	900	.4666	.4778	.4879	.5000	.5111	.5224	.5333	.5444	.5555
29	124	869	.4833	.4948	.5063	.5178	.5293	.5410	.5524	.5639	.5754
30	120	840	.5000	.5119	.5238	.5357	.5476	.5597	.5714	.5833	.5952
31	116	813	.5166	.5290	.5413	.5535	.5658	.5783	.5905	.6028	.6150
32	112	787	.5333	.5460	.5587	.5714	.5841	.5970	.6095	.6222	.6349
33	109	764	.5500	.5631	.5762	.5892	.6023	.6156	.6286	.6417	.6547
34	106	741	.5666	.5801	.5936	.6071	.6206	.6343	.6476	.6611	.6746
35	103	720	.5833	.5972	.6111	.6250	.6389	.6530	.6666	.6805	.6944
36	100	700	.6000	.6143	.6286	.6428	.6571	.6716	.6857	.7000	.7142
37	97	681	.6166	.6313	.6460	.6607	.6754	.6903	.7047	.7194	.7341
38	95	663	.6333	.6484	.6635	.6785	.6936	.7089	.7238	.7389	.7539
39	92	646	.6500	.6655	.6809	.6964	.7119	.7276	.7428	.7583	.7738
40	90	630	.6666	.6825	.6984	.7142	.7301	.7462	.7619	.7778	.7936
41	88	615	.6833	.6996	.7159	.7321	.7484	.7649	.7809	.7972	.8134
42	86	600	.7000	.7166	.7333	.7500	.7666	.7833	.8000	.8166	.8333
43	84	586	.7166	.7337	.7508	.7678	.7849	.8022	.8190	.8361	.8531
44	82	573	.7333	.7508	.7682	.7857	.8031	.8209	.8381	.8555	.8730
45	80	560	.7500	.7678	.7857	.8035	.8214	.8395	.8571	.8750	.8928
46	78	548	.7666	.7849	.8032	.8214	.8396	.8582	.8762	.8944	.9126
47	76	536	.7833	.8020	.8206	.8392	.8579	.8768	.8952	.9139	.9325
48	75	525	.8000	.8190	.8381	.8571	.8761	.8955	.9143	.9333	.9523
49	73	514	.8166	.8361	.8555	.8749	.8944	.9141	.9333	.9528	.9722
50	72	504	.8333	.8532	.8730	.8923	.9127	.9328	.9524	.9722	.9920
51	71	494	.8500	.8702	.8905	.9107	.9309	.9515	.9714	.9916	1.012
52	69	485	.8666	.8873	.9079	.9285	.9492	.9701	.9904	1.011	1.032
53	68	475	.8833	.9043	.9254	.9464	.9674	.9883	1.009	1.031	1.052
54	67	467	.9000	.9214	.9428	.9642	.9857	1.007	1.029	1.050	1.071
55	65	458	.9166	.9385	.9603	.9822	1.004	1.026	1.048	1.069	1.091
56	64	450	.9333	.9555	.9778	.9999	1.022	1.045	1.067	1.089	1.111
57	63	442	.9500	.9726	.9952	1.018	1.040	1.063	1.086	1.108	1.131
58	62	434	.9666	.9897	1.013	1.036	1.059	1.082	1.105	1.128	1.151
59	61	427	.9833	1.007	1.030	1.054	1.077	1.101	1.124	1.147	1.171
60	60	420	1.000	1.024	1.048	1.071	1.095	1.119	1.143	1.167	1.190

PIECE WORK RATE-SETTING TABLE

SEVEN HOURS A DAY

Minutes to do One Piece	No. of Pieces in Seven Hours	AMOUNT PER DAY								
		1.50	1.60	1.70	1.75	1.80	1.90	2.00	2.10	2.25
		RATE PER 100 PIECES								
1	420	.36	.38	.40	.42	.43	.45	.43	.50	.54
2	210	.71	.76	.81	.83	.86	.90	.95	1.00	1.07
3	140	1.07	1.14	1.21	1.25	1.29	1.36	1.43	1.50	1.61
4	105	1.43	1.52	1.62	1.66	1.71	1.81	1.90	2.00	2.14
5	84	1.79	1.90	2.02	2.08	2.14	2.26	2.38	2.50	2.68
6	70	2.14	2.28	2.43	2.49	2.57	2.71	2.86	3.00	3.21
7	60	2.50	2.66	2.83	2.91	3.00	3.17	3.33	3.50	3.75
8	52.5	2.86	3.05	3.24	3.33	3.43	3.62	3.81	4.00	4.28
9	46.7	3.21	3.43	3.64	3.74	3.86	4.07	4.29	4.50	4.82
10	42	3.57	3.81	4.05	4.16	4.29	4.52	4.76	5.00	5.36
11	38.2	3.93	4.19	4.45	4.57	4.71	4.98	5.24	5.50	5.89
12	35	4.29	4.57	4.86	4.99	5.14	5.43	5.71	6.00	6.43
13	32.3	4.64	4.95	5.26	5.40	5.57	5.88	6.19	6.50	6.96
14	30	5.00	5.33	5.67	5.82	6.00	6.33	6.67	7.00	7.50
15	28	5.36	5.71	6.07	6.24	6.43	6.79	7.14	7.50	8.03
16	26.2	5.71	6.09	6.48	6.65	6.86	7.24	7.62	8.00	8.57
17	24.7	6.07	6.47	6.88	7.07	7.29	7.69	8.10	8.50	9.11
18	23.3	6.43	6.85	7.29	7.48	7.71	8.14	8.57	9.00	9.64
19	22.1	6.78	7.23	7.69	7.90	8.14	8.60	9.05	9.50	10.18
20	21	7.14	7.61	8.10	8.31	8.57	9.05	9.52	10.00	10.71
21	20	7.50	7.99	8.50	8.73	9.00	9.50	10.00	10.50	11.25
22	19.1	7.86	8.38	8.91	9.15	9.43	9.95	10.48	11.00	11.78
23	18.3	8.21	8.76	9.31	9.56	9.86	10.41	10.95	11.50	12.32
24	17.5	8.57	9.14	9.72	9.98	10.29	10.86	11.43	12.00	12.85
25	16.8	8.93	9.52	10.12	10.39	10.72	11.31	11.91	12.50	13.39
26	16.2	9.28	9.90	10.52	10.81	11.14	11.76	12.38	13.00	13.93
27	15.6	9.64	10.28	10.93	11.22	11.57	12.21	12.86	13.50	14.46
28	15	10.00	10.66	11.33	11.64	12.00	12.67	13.33	14.00	15.00
29	14.5	10.36	11.04	11.74	12.06	12.43	13.12	13.81	14.50	15.53
30	14	10.71	11.42	12.14	12.47	12.86	13.57	14.29	15.00	16.07
31	13.5	11.07	11.80	12.55	12.89	13.29	14.02	14.76	15.50	16.60
32	13.1	11.43	12.18	12.95	13.30	13.72	14.48	15.24	16.00	17.14
33	12.7	11.78	12.56	13.36	13.72	14.14	14.94	15.71	16.50	17.67
34	12.4	12.14	12.94	13.76	14.13	14.57	15.38	16.19	17.00	18.21
35	12	12.50	13.32	14.17	14.55	15.00	15.83	16.67	17.50	18.75
36	11.7	12.86	13.71	14.57	14.97	15.43	16.29	17.14	18.00	19.28
37	11.4	13.21	14.09	14.98	15.38	15.86	16.74	17.62	18.50	19.82
38	11.1	13.57	14.47	15.38	15.80	16.29	17.19	18.10	19.00	20.35
39	10.8	13.93	14.85	15.79	16.21	16.72	17.64	18.57	19.50	20.89
40	10.5	14.28	15.23	16.19	16.63	17.14	18.10	19.05	20.00	21.42
41	10.2	14.64	15.61	16.60	17.04	17.57	18.55	19.52	20.50	21.96
42	10	15.00	15.99	17.00	17.46	18.00	19.00	20.00	21.00	22.50
43	9.8	15.36	16.37	17.41	17.88	18.43	19.45	20.48	21.50	23.03
44	9.5	15.71	16.75	17.81	18.29	18.86	19.91	20.95	22.00	23.57
45	9.3	16.07	17.13	18.22	18.71	19.29	20.36	21.43	22.50	24.10
46	9.1	16.43	17.51	18.62	19.12	19.72	20.81	21.91	23.00	24.64
47	8.9	16.78	17.89	19.03	19.54	20.14	21.26	22.38	23.50	25.17
48	8.7	17.14	18.27	19.43	19.95	20.57	21.72	22.86	24.00	25.71
49	8.6	17.50	18.65	19.84	20.37	21.00	22.17	23.33	24.50	26.24
50	8.4	17.86	19.04	20.24	20.79	21.43	22.62	23.81	25.00	26.78
51	8.2	18.21	19.42	20.64	21.20	21.86	23.07	24.29	25.50	27.32
52	8.1	18.57	19.80	21.05	21.62	22.29	23.52	24.76	26.00	27.85
53	7.9	18.93	20.18	21.45	22.03	22.72	23.98	25.24	26.50	28.39
54	7.8	19.28	20.56	21.86	22.45	23.14	24.43	25.71	27.00	28.92
55	7.6	19.64	20.94	22.26	22.86	23.57	24.88	26.19	27.50	29.46
56	7.5	20.00	21.32	22.67	23.28	24.00	25.33	26.67	28.00	29.99
57	7.4	20.35	21.70	23.07	23.69	24.43	25.79	27.14	28.50	30.53
58	7.3	20.71	22.08	23.48	24.11	24.86	26.24	27.62	29.00	31.06
59	7.1	21.07	22.46	23.88	24.53	25.29	26.69	28.10	29.50	31.60
60	7	21.43	22.84	24.29	24.94	25.72	27.14	28.57	30.00	32.14



PIECE WORK RATE-SETTING TABLE

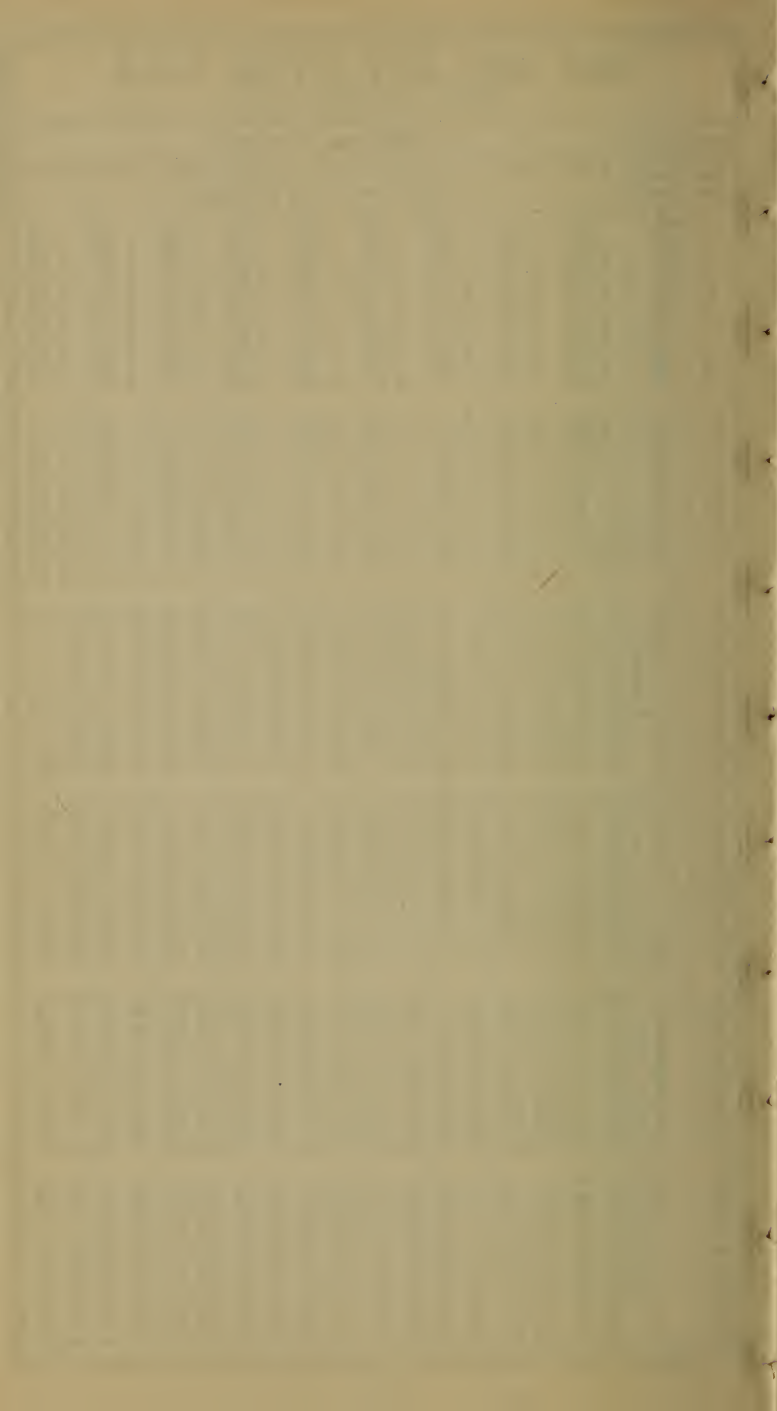
SEVEN HOURS A DAY

Minutes to do One Piece	No. of Pieces in Seven Hours	AMOUNT PER DAY								
		2.40	2.50	2.60	2.75	2.80	2.90	3.00	3.10	3.20
		RATE PER 100 PIECES								
1	420	.57	.60	.62	.65	.67	.69	.71	.74	.76
2	210	1.14	1.19	1.24	1.31	1.33	1.38	1.43	1.48	1.52
3	140	1.71	1.79	1.86	1.96	2.00	2.07	2.14	2.21	2.28
4	105	2.29	2.38	2.48	2.62	2.67	2.76	2.86	2.95	3.05
5	84	2.86	2.98	3.10	3.27	3.33	3.45	3.57	3.69	3.81
6	70	3.43	3.57	3.71	3.93	4.00	4.14	4.29	4.43	4.57
7	60	4.00	4.17	4.33	4.58	4.67	4.83	5.00	5.17	5.33
8	52.5	4.57	4.76	4.95	5.24	5.33	5.52	5.72	5.90	6.09
9	46.7	5.14	5.36	5.57	5.89	6.00	6.22	6.43	6.64	6.85
10	42	5.72	5.95	6.19	6.55	6.67	6.91	7.15	7.38	7.61
11	38.2	6.29	6.55	6.81	7.20	7.33	7.60	7.86	8.12	8.38
12	35	6.86	7.14	7.43	7.86	8.00	8.29	8.58	8.86	9.14
13	32.3	7.43	7.74	8.05	8.51	8.67	8.98	9.29	9.60	9.90
14	30	8.00	8.33	8.67	9.17	9.33	9.67	10.00	10.33	10.66
15	28	8.57	8.93	9.29	9.82	10.00	10.36	10.72	11.07	11.42
16	26.2	9.14	9.52	9.90	10.48	10.67	11.05	11.43	11.81	12.18
17	24.7	9.72	10.12	10.52	11.13	11.33	11.74	12.15	12.55	12.94
18	23.3	10.29	10.71	11.14	11.78	12.00	12.43	12.86	13.29	13.71
19	22.1	10.86	11.31	11.76	12.44	12.67	13.12	13.58	14.02	14.47
20	21	11.43	11.90	12.38	13.09	13.33	13.81	14.29	14.76	15.23
21	20	12.00	12.50	13.00	13.75	14.00	14.50	15.01	15.50	15.99
22	19.1	12.57	13.09	13.62	14.40	14.67	15.19	15.72	16.24	16.75
23	18.3	13.14	13.69	14.24	15.06	15.33	15.88	16.44	16.98	17.51
24	17.5	13.72	14.28	14.86	15.71	16.00	16.57	17.15	17.71	18.27
25	16.8	14.29	14.88	15.48	16.37	16.67	17.27	17.87	18.45	19.04
26	16.2	14.86	15.48	16.09	17.02	17.33	17.96	18.58	19.19	19.80
27	15.6	15.43	16.07	16.71	17.68	18.00	18.65	19.29	19.93	20.56
28	15	16.00	16.67	17.33	18.33	18.67	19.34	20.01	20.67	21.32
29	14.5	16.57	17.26	17.95	18.99	19.33	20.03	20.72	21.40	22.08
30	14	17.15	17.86	18.57	19.64	20.00	20.72	21.44	22.14	22.84
31	13.5	17.72	18.45	19.19	20.30	20.67	21.41	22.15	22.88	23.60
32	13.1	18.29	19.05	19.81	20.95	21.33	22.10	22.87	23.62	24.36
33	12.7	18.86	19.64	20.43	21.61	22.00	22.79	23.58	24.36	25.13
34	12.4	19.43	20.24	21.05	22.26	22.67	23.48	24.30	25.10	25.89
35	12	20.00	20.83	21.67	22.91	23.33	24.17	25.01	25.83	26.65
36	11.7	20.57	21.43	22.28	23.57	24.00	24.86	25.73	26.57	27.41
37	11.4	21.15	22.02	22.90	24.22	24.67	25.55	26.44	27.31	28.17
38	11.1	21.72	22.62	23.52	24.88	25.33	26.24	27.15	28.05	28.93
39	10.8	22.29	23.21	24.14	25.53	26.00	26.93	27.87	28.79	29.69
40	10.5	22.86	23.81	24.76	26.19	26.67	27.62	28.58	29.52	30.46
41	10.2	23.43	24.40	25.38	26.84	27.33	28.31	29.30	30.26	31.22
42	10	24.00	25.00	26.00	27.50	28.00	29.01	30.01	31.00	31.98
43	9.8	24.57	25.59	26.62	28.15	28.67	29.70	30.73	31.74	32.74
44	9.5	25.15	26.19	27.24	28.81	29.33	30.39	31.44	32.48	33.50
45	9.3	25.72	26.78	27.86	29.46	30.00	31.08	32.16	33.21	34.26
46	9.1	26.29	27.38	28.47	30.12	30.67	31.77	32.87	33.95	35.02
47	8.9	26.86	27.97	29.09	30.77	31.33	32.46	33.59	34.69	35.79
48	8.7	27.43	28.57	29.71	31.43	32.00	33.15	34.30	35.43	36.55
49	8.6	28.00	29.16	30.33	32.08	32.67	33.84	35.02	36.17	37.31
50	8.4	28.58	29.76	30.95	32.74	33.34	34.53	35.73	36.91	38.07
51	8.2	29.15	30.36	31.57	33.39	34.00	35.22	36.44	37.64	38.83
52	8.1	29.72	30.95	32.19	34.04	34.67	35.91	37.16	38.38	39.59
53	7.9	30.29	31.55	32.81	34.70	35.34	36.60	37.87	39.12	40.35
54	7.8	30.86	32.14	33.43	35.35	36.00	37.29	38.59	39.86	41.12
55	7.6	31.43	32.74	34.05	36.01	36.67	37.98	39.30	40.60	41.88
56	7.5	32.00	33.33	34.66	36.66	37.34	38.67	40.02	41.33	42.64
57	7.4	32.58	33.93	35.28	37.32	38.00	39.36	40.73	42.07	43.40
58	7.3	33.15	34.52	35.90	37.97	38.67	40.05	41.45	42.81	44.16
59	7.1	33.72	35.12	36.52	38.63	39.34	40.75	42.16	43.55	44.92
60	7	34.29	35.71	37.14	39.28	40.00	41.44	42.88	44.29	45.68

PIECE WORK RATE-SETTING TABLE

SEVEN HOURS A DAY

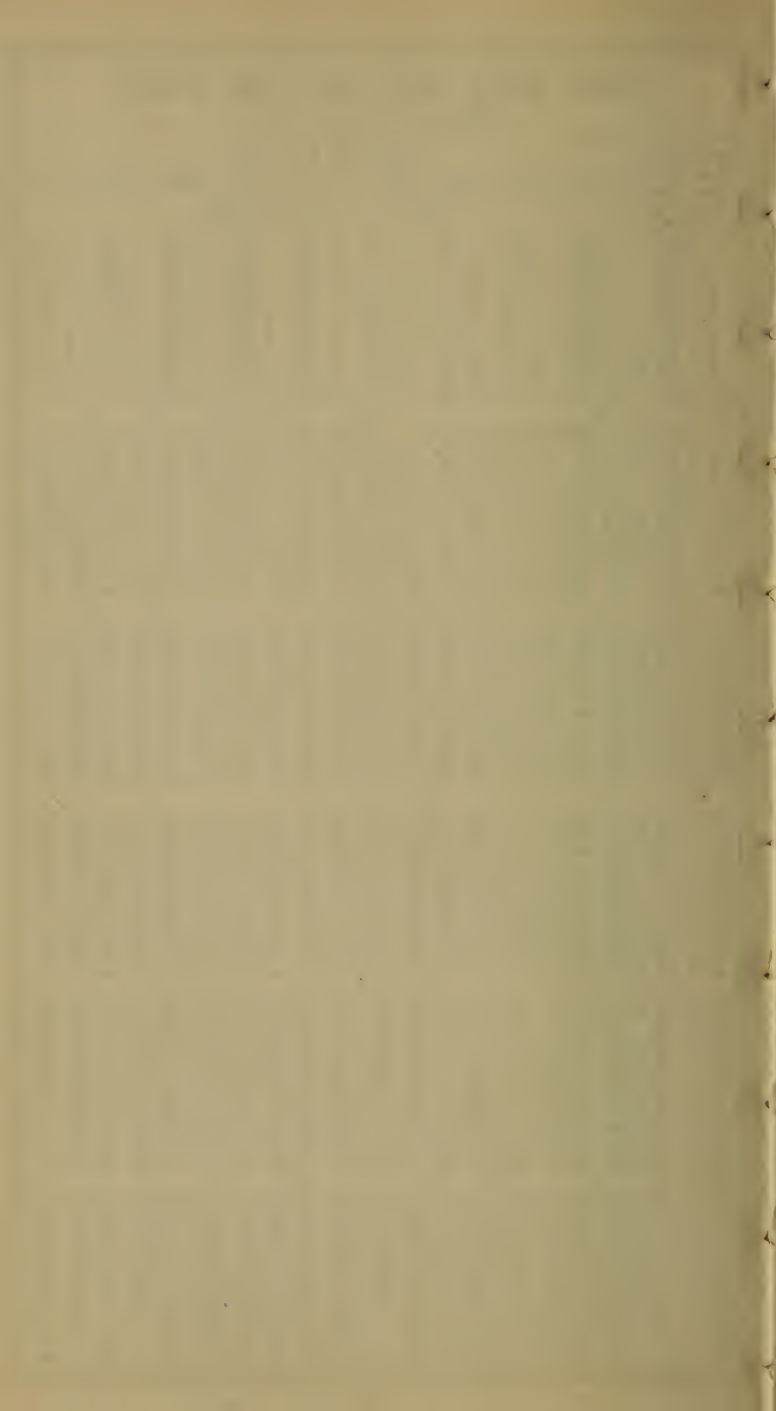
Minutes to do One Piece	No. of Pieces in Seven Hours	AMOUNT PER DAY								
		3.30	3.40	3.50	3.60	3.70	3.80	3.90	4.00	4.10
		RATE PER 100 PIECES								
1	420	.79	.81	.83	.86	.88	.90	.93	.95	.98
2	210	1.57	1.62	1.67	1.71	1.76	1.81	1.86	1.90	1.95
3	140	2.36	2.43	2.50	2.57	2.64	2.71	2.79	2.86	2.93
4	105	3.14	3.24	3.33	3.43	3.52	3.62	3.71	3.81	3.90
5	84	3.93	4.05	4.17	4.29	4.41	4.52	4.64	4.76	4.88
6	70	4.71	4.86	5.00	5.14	5.29	5.43	5.57	5.71	5.86
7	60	5.50	5.67	5.83	6.00	6.17	6.33	6.50	6.67	6.83
8	52.5	6.29	6.48	6.67	6.86	7.05	7.24	7.43	7.63	7.81
9	46.7	7.07	7.29	7.50	7.71	7.93	8.14	8.36	8.57	8.78
10	42	7.86	8.11	8.33	8.57	8.81	9.05	9.29	9.52	9.76
11	38.2	8.64	8.92	9.17	9.43	9.69	9.95	10.21	10.48	10.74
12	35	9.43	9.73	10.00	10.29	10.57	10.86	11.14	11.43	11.71
13	32.3	10.21	10.54	10.83	11.14	11.45	11.76	12.07	12.38	12.69
14	30	11.00	11.35	11.67	12.00	12.33	12.67	13.00	13.33	13.67
15	28	11.79	12.16	12.50	12.86	13.22	13.57	13.93	14.29	14.64
16	26.2	12.57	12.97	13.33	13.71	14.10	14.48	14.86	15.24	15.62
17	24.7	13.36	13.78	14.17	14.57	14.98	15.38	15.79	16.19	16.59
18	23.3	14.14	14.59	15.00	15.43	15.86	16.28	16.71	17.14	17.57
19	22.1	14.93	15.40	15.83	16.28	16.74	17.19	17.65	18.10	18.55
20	21	15.71	16.21	16.67	17.14	17.62	18.09	18.57	19.05	19.52
21	20	16.50	17.02	17.50	18.00	18.50	19.00	19.50	20.00	20.50
22	19.1	17.29	17.83	18.33	18.86	19.38	19.90	20.43	20.95	21.47
23	18.3	18.07	18.64	19.17	19.71	20.26	20.81	21.36	21.91	22.45
24	17.5	18.86	19.45	20.00	20.57	21.14	21.71	22.29	22.86	23.43
25	16.8	19.64	20.26	20.83	21.43	22.03	22.62	23.22	23.81	24.40
26	16.2	20.43	21.07	21.67	22.28	22.91	23.52	24.14	24.76	25.38
27	15.6	21.21	21.88	22.50	23.14	23.79	24.43	25.07	25.71	26.35
28	15	22.00	22.69	23.33	24.00	24.67	25.33	26.00	26.67	27.33
29	14.5	22.79	23.50	24.17	24.86	25.55	26.24	26.94	27.62	28.31
30	14	23.57	24.32	25.00	25.71	26.43	27.14	27.86	28.57	29.28
31	13.5	24.36	25.13	25.83	26.57	27.31	28.05	28.79	29.52	30.26
32	13.1	25.14	25.94	26.67	27.43	28.19	28.95	29.72	30.48	31.24
33	12.7	25.93	26.75	27.50	28.28	29.07	29.86	30.64	31.43	32.21
34	12.4	26.71	27.56	28.33	29.14	29.95	30.76	31.57	32.38	33.19
35	12	27.50	28.37	29.17	30.00	30.84	31.66	32.50	33.33	34.16
36	11.7	28.29	29.18	30.00	30.86	31.72	32.57	33.43	34.29	35.14
37	11.4	29.07	29.99	30.83	31.71	32.60	33.47	34.36	35.24	36.12
38	11.1	29.86	30.80	31.67	32.57	33.48	34.38	35.29	36.29	37.09
39	10.8	30.64	31.61	32.50	33.43	34.36	35.28	36.22	37.14	38.07
40	10.5	31.43	32.42	33.33	34.28	35.24	36.19	37.14	38.10	39.04
41	10.2	32.21	33.23	34.17	35.14	36.12	37.09	38.07	39.05	40.02
42	10	33.00	34.04	35.00	36.00	37.00	38.00	39.00	40.00	41.00
43	9.8	33.79	34.85	35.83	36.86	37.88	38.90	39.93	40.95	41.97
44	9.5	34.57	35.66	36.67	37.71	38.76	39.81	40.86	41.91	42.95
45	9.3	35.36	36.47	37.50	38.57	39.65	40.71	41.79	42.86	43.92
46	9.1	36.14	37.28	38.33	39.43	40.53	41.62	42.72	43.81	44.90
47	8.9	36.93	38.09	39.17	40.28	41.41	42.52	43.64	44.76	45.88
48	8.7	37.71	38.90	40.00	41.14	42.29	43.43	44.57	45.72	46.85
49	8.6	38.50	39.71	40.83	42.00	43.17	44.33	45.50	46.67	47.83
50	8.4	39.29	40.53	41.67	42.86	44.05	45.24	46.43	47.62	48.81
51	8.2	40.07	41.34	42.50	43.71	44.93	46.14	47.36	48.57	49.78
52	8.1	40.86	42.15	43.33	44.57	45.81	47.04	48.29	49.52	50.76
53	7.9	41.64	42.96	44.17	45.43	46.69	47.95	49.22	50.48	51.73
54	7.8	42.43	43.77	45.00	46.28	47.57	48.85	50.14	51.43	52.71
55	7.6	43.21	44.58	45.83	47.14	48.46	49.76	51.07	52.38	53.69
56	7.5	44.00	45.39	46.66	48.00	49.34	50.66	52.00	53.33	54.66
57	7.4	44.78	46.20	47.50	48.85	50.22	51.57	52.93	54.29	55.64
58	7.3	45.57	47.01	48.33	49.71	51.10	52.47	53.86	55.24	56.61
59	7.1	46.36	47.82	49.16	50.57	51.98	53.38	54.79	56.19	57.59
60	7	47.14	48.63	50.00	51.43	52.86	54.28	55.72	57.14	58.57



PIECE WORK RATE-SETTING TABLE

SEVEN HOURS A DAY

Minutes to do One Piece	No. of Pieces in Seven Hours	AMOUNT PER DAY								
		4.20	4.30	4.40	4.50	4.60	4.70	4.80	4.90	5.00
		RATE PER 100 PIECES								
1	420	1.00	1.02	1.05	1.07	1.10	1.12	1.14	1.17	1.19
2	210	2.00	2.05	2.10	2.14	2.19	2.24	2.29	2.33	2.38
3	140	3.00	3.07	3.14	3.21	3.29	3.36	3.43	3.50	3.57
4	105	4.00	4.10	4.19	4.28	4.38	4.48	4.57	4.67	4.76
5	84	5.00	5.12	5.24	5.36	5.48	5.60	5.72	5.84	5.95
6	70	6.00	6.14	6.29	6.43	6.57	6.71	6.86	7.00	7.14
7	60	7.00	7.17	7.34	7.50	7.67	7.83	8.00	8.17	8.33
8	52.5	8.00	8.19	8.38	8.57	8.76	8.95	9.14	9.34	9.52
9	46.7	9.00	9.22	9.43	9.64	9.86	10.07	10.29	10.50	10.71
10	42	10.00	10.24	10.48	10.71	10.95	11.19	11.43	11.67	11.90
11	38.2	11.00	11.26	11.53	11.78	12.05	12.31	12.57	12.84	13.09
12	35	12.00	12.29	12.58	12.85	13.14	13.43	13.72	14.00	14.28
13	32.3	13.00	13.31	13.62	13.92	14.24	14.55	14.86	15.17	15.47
14	30	14.00	14.34	14.67	14.99	15.33	15.67	16.00	16.34	16.66
15	28	15.00	15.36	15.72	16.07	16.43	16.79	17.15	17.51	17.85
16	26.2	16.00	16.38	16.77	17.14	17.52	17.90	18.29	18.67	19.04
17	24.7	17.00	17.41	17.82	18.21	18.62	19.02	19.43	19.84	20.23
18	23.3	18.00	18.43	18.86	19.28	19.71	20.14	20.57	21.01	21.42
19	22.1	19.00	19.46	19.91	20.35	20.81	21.26	21.72	22.17	22.61
20	21	20.00	20.48	20.96	21.42	21.90	22.38	22.86	23.34	23.80
21	20	21.00	21.50	22.00	22.49	23.00	23.50	24.00	24.51	24.99
22	19.1	22.00	22.53	23.06	23.56	24.09	24.62	25.15	25.67	26.18
23	18.3	23.00	23.55	24.10	24.63	25.19	25.74	26.29	26.84	27.37
24	17.5	24.00	24.58	25.15	25.70	26.28	26.86	27.43	28.01	28.56
25	16.8	25.00	25.60	26.20	26.78	27.38	27.98	28.58	29.18	29.75
26	16.2	26.00	26.62	27.25	27.85	28.47	29.09	29.72	30.34	30.94
27	15.6	27.00	27.65	28.30	28.92	29.57	30.21	30.86	31.51	32.13
28	15	28.00	28.67	29.34	29.99	30.66	31.33	32.00	32.68	33.32
29	14.5	29.00	29.70	30.39	31.06	31.76	32.45	33.15	33.84	34.51
30	14	30.00	30.72	31.44	32.13	32.85	33.57	34.29	35.01	35.70
31	13.5	31.00	31.74	32.49	33.20	33.95	34.69	35.43	36.18	36.89
32	13.1	32.00	32.77	33.54	34.27	35.04	35.81	36.58	37.34	38.08
33	12.7	33.00	33.79	34.58	35.34	36.14	36.93	37.72	38.51	39.27
34	12.4	34.00	34.82	35.63	36.41	37.23	38.05	38.86	39.68	40.46
35	12	35.00	35.84	36.68	37.49	38.33	39.17	40.00	40.85	41.65
36	11.7	36.00	36.86	37.73	38.56	39.42	40.28	41.15	42.01	42.84
37	11.4	37.00	37.89	38.78	39.63	40.52	41.40	42.29	43.18	44.03
38	11.1	38.00	38.91	39.82	40.70	41.61	42.52	43.43	44.35	45.22
39	10.8	39.00	39.94	40.87	41.77	42.71	43.64	44.58	45.51	46.41
40	10.5	40.00	40.96	41.92	42.84	43.80	44.76	45.72	46.68	47.60
41	10.2	41.00	41.98	42.97	43.91	44.90	45.88	46.86	47.85	48.79
42	10	42.00	43.00	44.02	44.98	45.99	47.00	48.00	49.01	49.98
43	9.8	43.00	44.03	45.07	46.05	47.09	48.12	49.15	50.18	51.17
44	9.5	44.00	45.06	46.11	47.12	48.18	49.24	50.29	51.35	52.36
45	9.3	45.00	46.08	47.16	48.20	49.28	50.36	51.44	52.52	53.55
46	9.1	46.00	47.10	48.21	49.27	50.37	51.47	52.58	53.68	54.74
47	8.9	47.00	48.13	49.26	50.34	51.47	52.59	53.72	54.85	55.93
48	8.7	48.00	49.15	50.31	51.41	52.56	53.71	54.86	56.02	57.12
49	8.6	49.00	50.18	51.35	52.48	53.66	54.83	56.00	57.18	58.31
50	8.4	50.00	51.20	52.40	53.55	54.75	55.95	57.15	58.35	59.50
51	8.2	51.00	52.22	53.45	54.62	55.85	57.07	58.29	59.52	60.69
52	8.1	52.00	53.25	54.50	55.69	56.94	58.19	59.44	60.68	61.88
53	7.9	53.00	54.27	55.55	56.76	58.04	59.31	60.58	61.85	63.07
54	7.8	54.00	55.30	56.59	57.83	59.13	60.43	61.72	63.02	64.26
55	7.6	55.00	56.32	57.64	58.91	60.23	61.55	62.87	64.19	65.45
56	7.5	56.00	57.34	58.69	59.98	61.32	62.66	64.00	65.35	66.64
57	7.4	57.00	58.37	59.74	61.05	62.42	63.78	65.15	66.52	67.83
58	7.3	58.00	59.39	60.79	62.12	63.51	64.90	66.29	67.69	69.02
59	7.1	59.00	60.42	61.83	63.19	64.61	66.02	67.44	68.85	70.21
60	7	60.00	61.44	62.88	64.26	65.70	67.14	68.58	70.02	71.40



PIECE WORK RATE-SETTING TABLE

SEVEN HOURS A DAY

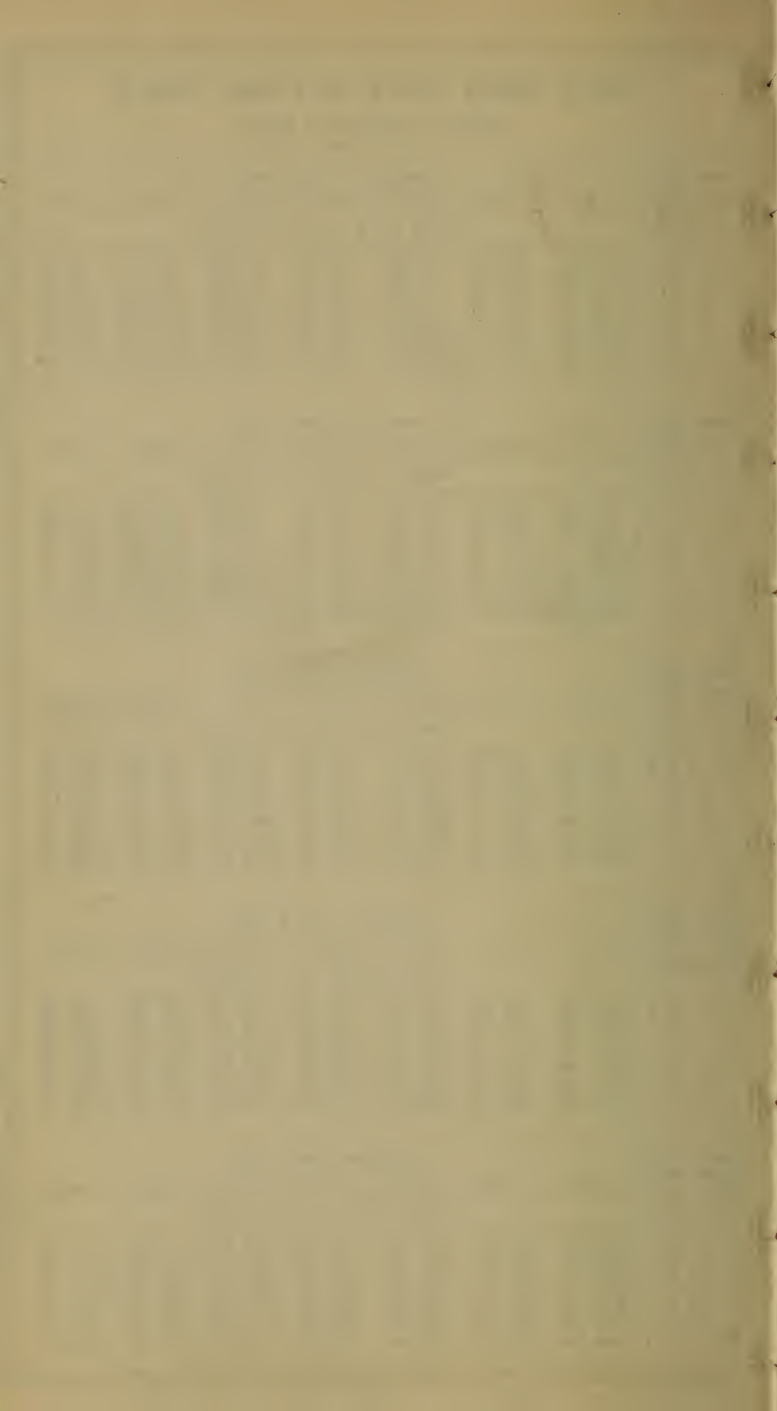
Hours to do One Piece	No. of Pieces in 7 Hours	AMOUNT PER DAY						
		1.50	1.60	1.75	1.80	1.90	2.00	2.10
		RATE PER 100 PIECES						
1	7	21.43	22.84	24.94	25.72	27.14	28.57	30.00
2	3.5	42.86	45.68	49.88	51.44	54.28	57.14	60.00
3	2 $\frac{1}{3}$	64.29	68.52	74.82	77.16	81.42	85.71	90.00
4	1 $\frac{3}{4}$	85.72	91.36	99.76	102.83	108.56	114.28	120.00
5	1.4	107.15	114.20	124.70	128.60	135.70	142.85	150.00
6	1 $\frac{1}{8}$	128.58	137.04	149.64	154.32	162.84	171.42	180.00
7	1	150.00	160.00	175.00	180.00	190.00	200.00	210.00

Hours to do One Piece	No. of Pieces in 7 Hours	AMOUNT PER DAY						
		2.25	2.40	2.50	2.60	2.75	2.80	2.90
		RATE PER 100 PIECES						
1	7	32.14	34.29	35.71	37.14	39.28	40.00	41.44
2	3.5	64.28	68.58	71.42	74.28	78.56	80.00	82.88
3	2 $\frac{1}{3}$	96.42	102.87	107.13	111.42	117.84	120.00	124.32
4	1 $\frac{3}{4}$	128.56	137.16	142.84	148.56	157.12	160.00	165.76
5	1.4	160.70	171.45	178.55	185.70	196.40	200.00	207.20
6	1 $\frac{1}{8}$	192.84	205.74	214.26	222.84	235.68	240.00	248.64
7	1	225.00	240.00	250.00	260.00	275.00	280.00	290.00

Hours to do One Piece	No. of Pieces in 7 Hours	AMOUNT PER DAY						
		3.00	3.10	3.20	3.30	3.40	3.50	3.60
		RATE PER 100 PIECES						
1	7	42.88	44.29	45.68	47.14	48.63	50.00	51.43
2	3.5	85.76	88.58	91.36	94.28	97.26	100.00	102.86
3	2 $\frac{1}{3}$	128.64	132.87	137.04	141.42	145.89	150.00	154.29
4	1 $\frac{3}{4}$	171.52	177.16	182.72	188.56	194.52	200.00	205.72
5	1.4	214.40	221.45	228.40	235.70	243.15	250.00	257.15
6	1 $\frac{1}{8}$	257.28	265.74	274.08	282.84	291.78	300.00	308.58
7	1	300.00	310.00	320.00	330.00	340.00	350.00	360.00

Hours to do One Piece	No. of Pieces in 7 Hours	AMOUNT PER DAY						
		3.70	3.80	3.90	4.00	4.10	4.20	4.30
		RATE PER 100 PIECES						
1	7	52.86	54.28	55.72	57.14	58.57	60.00	61.44
2	3.5	105.72	108.56	111.44	114.28	117.14	120.00	122.88
3	2 $\frac{1}{3}$	158.58	162.84	167.16	171.42	175.71	180.00	184.32
4	1 $\frac{3}{4}$	211.44	217.12	222.88	228.56	234.28	240.00	245.76
5	1.4	264.30	271.40	278.60	285.70	292.85	300.00	307.20
6	1 $\frac{1}{8}$	317.16	325.68	334.32	342.84	351.42	360.00	368.64
7	1	370.00	380.00	390.00	400.00	410.00	420.00	430.00

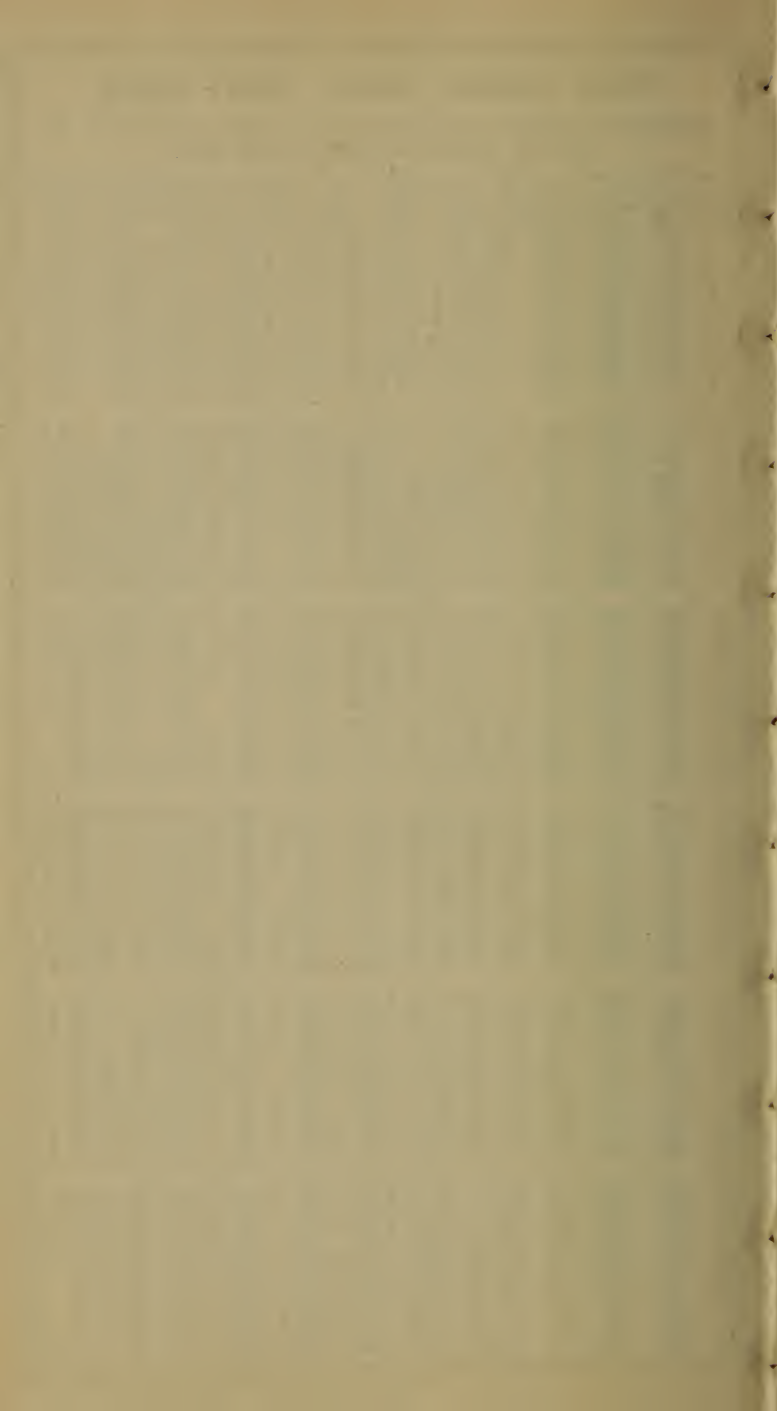
Hours to do One Piece	No. of Pieces in 7 Hours	AMOUNT PER DAY						
		4.40	4.50	4.60	4.70	4.80	4.90	5.00
		RATE PER 100 PIECES						
1	7	62.88	64.26	65.70	67.14	68.59	70.02	71.40
2	3.5	125.76	128.52	131.40	134.28	137.16	140.04	142.80
3	2 $\frac{1}{3}$	188.64	192.78	197.10	201.42	205.74	210.06	214.20
4	1 $\frac{3}{4}$	251.52	257.04	262.80	268.56	274.32	280.08	285.60
5	1.4	314.40	321.30	328.50	335.70	349.90	350.10	357.00
6	1 $\frac{1}{8}$	377.28	385.56	394.20	402.84	411.48	420.12	428.40
7	1	440.00	450.00	460.00	470.00	480.00	490.00	500.00



PIECE - FINDING TABLE — EIGHT HOURS

SHOWING NUMBER OF PIECES WHEN TIME REQUIRED TO
DO ONE PIECE IS OVER ONE MINUTE

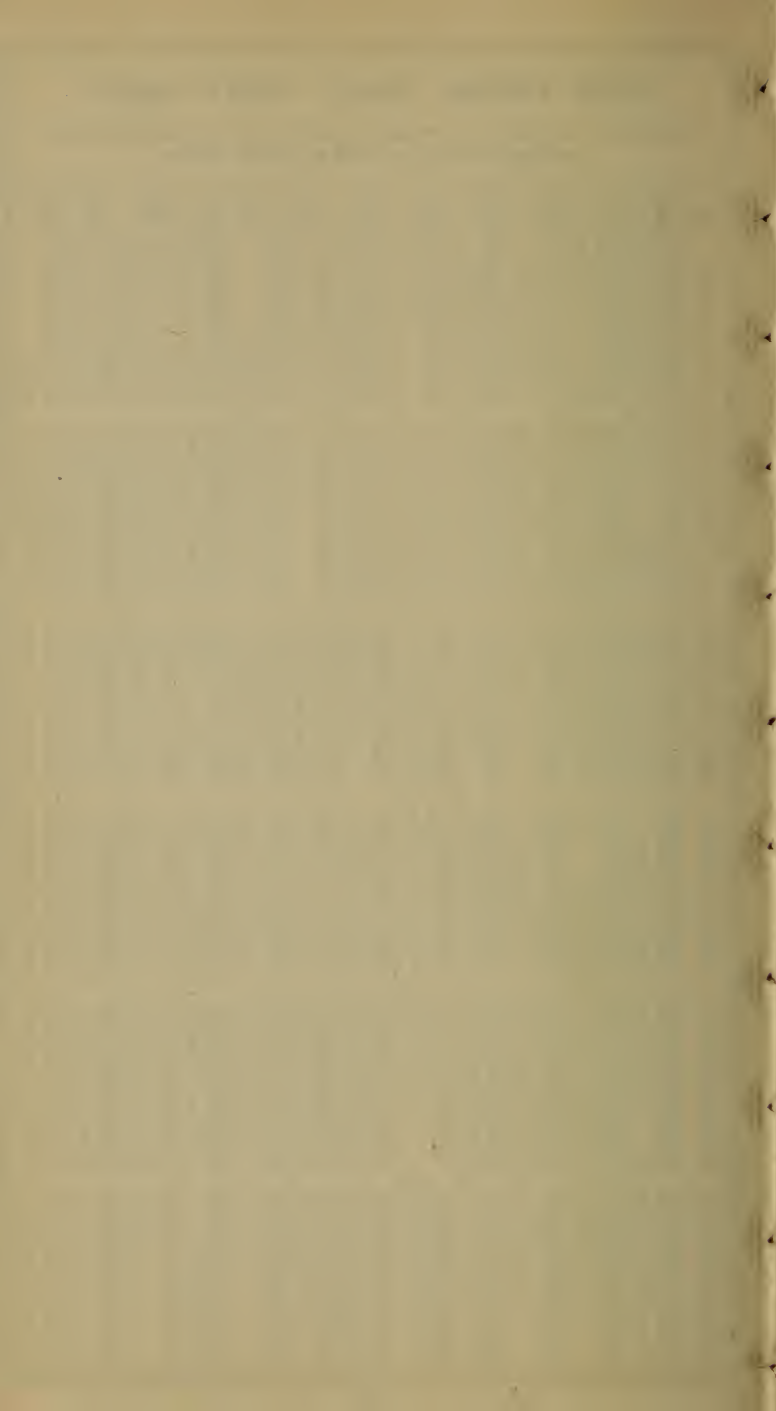
Sec.	1 Min	2 Min.	3 Min.	4 Min.	5 Min.	6 Min	7 Min.	8 Min.	9 Min.	10 Min.	11 Min.	12 Min.
1	480	240	160	120	96	80	63.6	60	53.3	48	43.6	40
2	472	238	159	120	95.7	79.8	68.4	59.8	53.2	47.9	43.5	39.9
3	464	236	158	119	95.4	79.6	68.3	59.7	53.1	47.8	43.4	39.9
4	457	234	157	119	95.1	79.4	68.1	59.6	53	47.7	43.4	39.8
5	450	232	156	118	94.9	79.2	68	59.5	52.9	47.7	43.3	39.8
6	443	230	155	118	94.6	79	67.8	59.4	52.8	47.6	43.3	39.8
7	436	228	154	118	94.3	78.8	67.7	59.3	52.7	47.5	43.2	39.7
8	430	226	154	117	94.1	78.6	67.5	59.2	52.6	47.4	43.1	39.7
9	423	225	153	117	93.8	78.4	67.4	59.1	52.5	47.4	43.1	39.7
10	417	223	152	116	93.5	78.3	67.3	58.9	52.5	47.3	43	39.6
11	411	221	151	116	93.3	78.1	67.1	58.8	52.4	47.2	43	39.6
12	406	220	151	116	93	77.9	67	58.7	52.3	47.1	42.9	39.6
13	400	218	150	115	92.7	77.7	66.8	58.6	52.2	47.1	42.8	39.5
14	394	216	149	115	92.5	77.5	66.7	58.5	52.1	47	42.8	39.5
15	389	215	148	114	92.2	77.3	66.5	58.4	52	46.9	42.7	39.5
16	384	213	147	114	91.9	77.1	66.4	58.3	51.9	46.9	42.7	39.4
17	379	211	146	114	91.7	76.9	66.3	58.2	51.8	46.8	42.6	39.4
18	374	210	146	113	91.4	76.7	66.1	58	51.7	46.7	42.5	39.4
19	369	208	145	113	91.1	76.6	66	57.9	51.7	46.6	42.5	39.3
20	365	206	145	112	90.9	76.4	65.8	57.8	51.6	46.6	42.4	39.3
21	360	205	144	112	90.6	76.2	65.7	57.7	51.5	46.5	42.4	39.2
22	355	204	144	112	90.3	76	65.5	57.6	51.4	46.4	42.3	39.2
23	351	203	143	111	90.1	75.8	65.4	57.5	51.3	46.3	42.2	39.2
24	347	201	142	111	89.8	75.6	65.3	57.4	51.2	46.3	42.2	39.1
25	342	200	141	110	89.5	75.4	65.1	57.3	51.1	46.2	42.1	39.1
26	339	199	140	110	89.3	75.2	65	57.2	51	46.1	42.1	39.1
27	334	197	140	110	89	75.1	64.8	57	51	46	42	39
28	331	196	139	109	88.7	74.9	64.7	56.9	50.9	46	41.9	39
29	327	194	138	109	88.5	74.7	64.5	56.8	50.8	45.9	41.9	39
30	323	193	138	108	88.2	74.5	64.4	56.7	50.7	45.8	41.8	38.9
31	320	192	137	108	87.9	74.3	64.3	56.6	50.6	45.8	41.8	38.9
32	316	191	136	108	87.7	74.1	64.1	56.5	50.5	45.7	41.7	38.9
33	313	189	135	107	87.4	73.9	64	56.4	50.4	45.6	41.6	38.8
34	309	188	135	107	87.1	73.7	63.8	56.3	50.3	45.5	41.5	38.8
35	306	187	134	106	86.9	73.5	63.7	56.1	50.2	45.5	41.5	38.8
36	303	186	134	106	86.6	73.4	63.5	56	50.2	45.4	41.4	38.7
37	300	184	133	106	86.3	73.2	63.4	55.9	50.1	45.3	41.4	38.7
38	296	183	133	105	86.1	73	63.2	55.8	50	45.2	41.3	38.6
39	293	182	132	105	85.8	72.8	63.1	55.7	49.9	45.2	41.2	38.6
40	290	181	131	104	84.5	72.6	63	55.6	49.8	45.1	41.2	38.6
41	288	180	131	104	84.3	72.4	62.8	55.5	49.7	45	41.1	38.5
42	285	178	130	104	84	72.2	62.7	55.4	49.6	44.9	41.1	38.5
43	282	177	130	103	83.7	72	62.5	55.3	49.5	44.9	41	38.5
44	279	176	129	103	83.5	71.9	62.4	55.1	49.5	44.8	40.9	38.4
45	276	175	129	102	83.2	71.7	62.2	55	49.4	44.7	40.9	38.4
46	273	174	128	102	82.9	71.5	62.1	54.9	49.3	44.7	40.8	38.4
47	271	173	127	102	82.7	71.3	62	54.8	49.2	44.6	40.8	38.3
48	269	172	127	101	82.4	71.1	61.8	54.7	49.1	44.5	40.7	38.3
49	266	171	126	101	82.1	70.9	61.7	54.6	49	44.4	40.6	38.3
50	264	170	126	100	81.9	70.7	61.5	54.5	48.9	44.3	40.6	38.2
51	262	169	125	100	81.6	70.5	61.4	54.4	48.8	44.3	40.5	38.2
52	260	168	125	100	81.3	70.3	61.2	54.2	48.7	44.2	40.5	38.2
53	257	167	124	99	81.1	70.2	61.1	54.1	48.7	44.1	40.4	38.1
54	254	166	124	99	80.8	70	61	54	48.6	44.1	40.3	38.1
55	252	165	123	98	80.5	69.8	60.8	53.9	48.5	44	40.3	38.1
56	250	164	123	98	80.3	69.6	60.7	53.8	48.4	43.9	40.2	38
57	248	163	122	98	80.2	69.4	60.5	53.7	48.3	43.8	40.2	38
58	246	162	122	97	80.2	69.2	60.4	53.6	48.2	43.8	40.1	38
59	244	161	121	97	80.1	69	60.2	53.5	48.2	43.7	40.1	37.9
60	242	160	121	96	80.1	68.8	60.1	53.4	48.1	43.6	40	37.9



PIECE-FINDING TABLE — EIGHT HOURS

SHOWING NUMBER OF PIECES WHEN TIME REQUIRED TO
DO ONE PIECE IS OVER ONE MINUTE

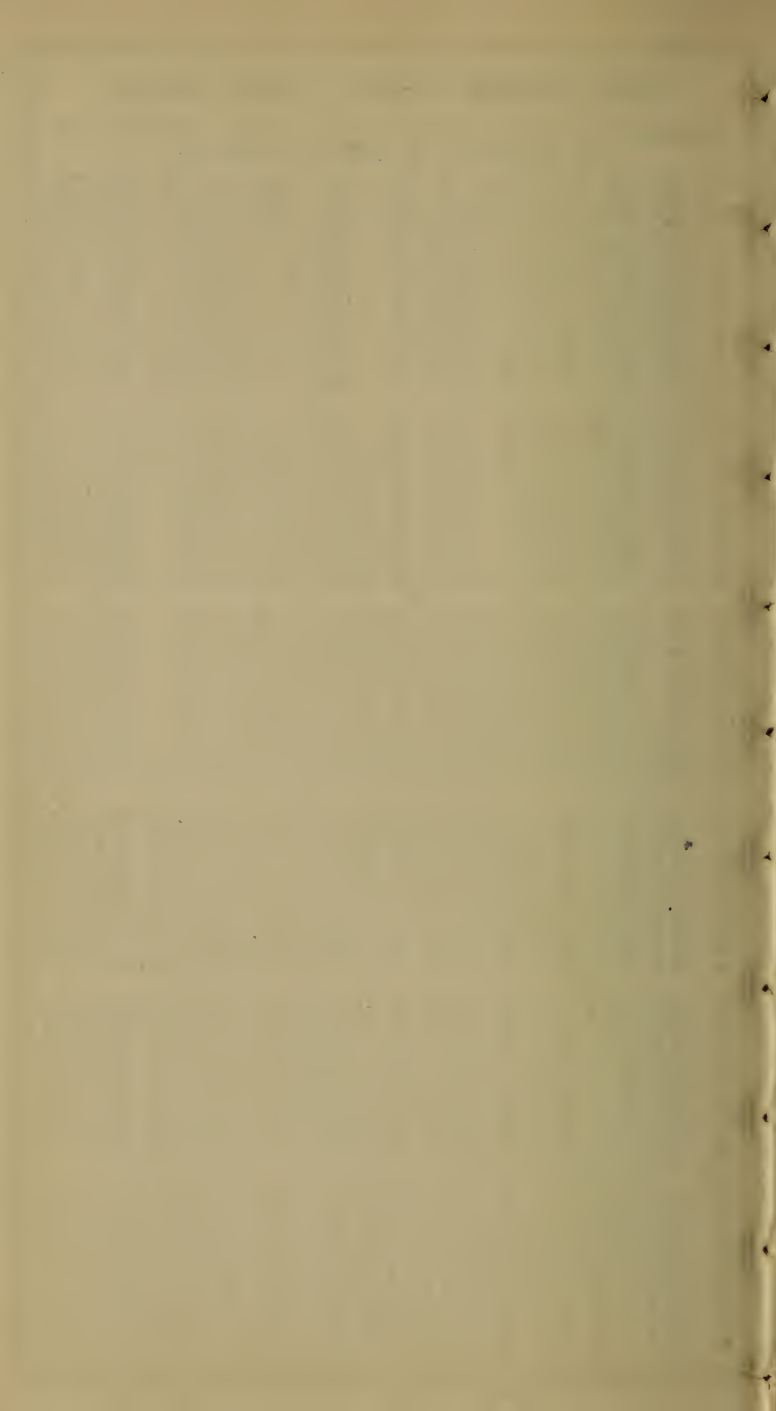
Sec.	13 Min.	14 Min.	15 Min.	16 Min.	17 Min.	18 Min.	19 Min.	20 Min.	21 Min.	22 Min.	23 Min.	24 Min.
1	37.9	34.3	32	30	28.2	26.7	25.3	24	22.9	21.8	20.9	20
2	37.8	34.2	31.9	29.9	28.1	26.7	25.3	24	22.9	21.8	20.9	20
3	37.7	34.1	31.9	29.9	28.1	26.6	25.3	24	22.9	21.8	20.9	20
4	37.6	34.1	31.8	29.8	28.1	26.6	25.3	24	22.9	21.8	20.9	20
5	37.6	34.1	31.8	29.8	28.1	26.6	25.2	24	22.9	21.8	20.9	20
6	37.5	34	31.8	29.8	28	26.6	25.2	23.9	22.8	21.8	20.8	20
7	37.4	34	31.7	29.7	28	26.5	25.2	23.9	22.8	21.7	20.8	19.9
8	37.4	33.9	31.7	29.7	28	26.5	25.2	23.9	22.8	21.7	20.8	19.9
9	37.3	33.9	31.7	29.7	28	26.5	25.2	23.9	22.8	21.7	20.8	19.9
10	37.3	33.9	31.6	29.6	27.9	26.5	25.1	23.9	22.8	21.7	20.8	19.9
11	37.2	33.8	31.6	29.6	27.9	26.4	25.1	23.8	22.7	21.7	20.8	19.9
12	37.1	33.8	31.6	29.6	27.9	26.4	25.1	23.8	22.7	21.7	20.7	19.9
13	37.1	33.8	31.5	29.5	27.9	26.4	25.1	23.8	22.7	21.6	20.7	19.9
14	37	33.7	31.5	29.5	27.8	26.4	25.1	23.8	22.7	21.6	20.7	19.9
15	37	33.7	31.5	29.5	27.8	26.3	25	23.8	22.7	21.6	20.7	19.8
16	36.9	33.6	31.4	29.4	27.8	26.3	25	23.8	22.7	21.6	20.7	19.8
17	36.8	33.6	31.4	29.4	27.8	26.3	25	23.7	22.6	21.6	20.7	19.8
18	36.8	33.6	31.4	29.4	27.7	26.3	25	23.7	22.6	21.6	20.6	19.8
19	36.7	33.5	31.3	29.3	27.7	26.2	25	23.7	22.6	21.5	20.6	19.8
20	36.7	33.5	31.3	29.3	27.7	26.2	24.9	23.7	22.6	21.5	20.6	19.8
21	36.6	33.4	31.3	29.3	27.7	26.2	24.9	23.7	22.6	21.5	20.6	19.8
22	36.5	33.4	31.2	29.2	27.6	26.2	24.9	23.6	22.5	21.5	20.6	19.7
23	36.5	33.4	31.2	29.2	27.6	26.1	24.9	23.6	22.5	21.5	20.6	19.7
24	36.4	33.3	31.2	29.2	27.6	26.1	24.9	23.6	22.5	21.5	20.5	19.7
25	36.4	33.3	31.1	29.1	27.6	26.1	24.8	23.6	22.5	21.4	20.5	19.7
26	36.3	33.3	31.1	29.1	27.5	26.1	24.8	23.6	22.5	21.4	20.5	19.7
27	36.2	33.2	31.1	29.1	27.5	26	24.8	23.5	22.5	21.4	20.5	19.7
28	36.2	33.2	31	29	27.5	26	24.8	23.5	22.4	21.4	20.5	19.7
29	36.1	33.1	31	29	27.5	26	24.8	23.5	22.4	21.4	20.5	19.6
30	36.1	33.1	31	29	27.4	26	24.7	23.5	22.4	21.4	20.4	19.6
31	36	33.1	30.9	28.9	27.4	25.9	24.7	23.5	22.4	21.3	20.4	19.6
32	35.9	33	30.9	28.9	27.4	25.9	24.7	23.4	22.4	21.3	20.4	19.6
33	35.9	33	30.9	28.9	27.4	25.9	24.7	23.4	22.3	21.3	20.4	19.6
34	35.8	32.9	30.8	28.8	27.3	25.9	24.7	23.4	22.3	21.3	20.4	19.6
35	35.8	32.9	30.8	28.8	27.3	25.8	24.6	23.4	22.3	21.3	20.4	19.6
36	35.7	32.9	30.8	28.8	27.3	25.8	24.6	23.4	22.3	21.3	20.4	19.6
37	35.6	32.8	30.7	28.7	27.3	25.8	24.6	23.4	22.3	21.3	20.3	19.5
38	35.6	32.8	30.7	28.7	27.2	25.8	24.5	23.3	22.3	21.2	20.3	19.5
39	35.5	32.8	30.7	28.7	27.2	25.7	24.5	23.3	22.2	21.2	20.3	19.5
40	35.5	32.7	30.6	28.6	27.2	25.7	24.5	23.3	22.2	21.2	20.3	19.5
41	35.4	32.7	30.6	28.6	27.2	25.7	24.5	23.3	22.2	21.2	20.3	19.5
42	35.3	32.6	30.6	28.6	27.1	25.7	24.4	23.3	22.2	21.2	20.3	19.5
43	35.3	32.6	30.5	28.6	27.1	25.6	24.4	23.2	22.2	21.2	20.3	19.4
44	35.2	32.6	30.5	28.5	27.1	25.6	24.4	23.2	22.1	21.2	20.2	19.4
45	35.2	32.5	30.5	28.5	27.1	25.6	24.4	23.2	22.1	21.1	20.2	19.4
46	35.1	32.5	30.4	28.5	27	25.6	24.3	23.2	22.1	21.1	20.2	19.4
47	35	32.4	30.4	28.5	27	25.5	24.3	23.2	22.1	21.1	20.2	19.4
48	35	32.4	30.4	28.5	27	25.5	24.3	23.1	22.1	21.1	20.2	19.4
49	34.9	32.4	30.3	28.4	27	25.5	24.3	23.1	22	21.1	20.2	19.4
50	34.9	32.3	30.3	28.4	26.9	25.5	24.3	23.1	22	21.1	20.2	19.4
51	34.8	32.3	30.3	28.4	26.9	25.4	24.2	23.1	22	21.1	20.1	19.3
52	34.7	32.3	30.2	28.4	26.9	25.4	24.2	23.1	22	21.1	20.1	19.3
53	34.7	32.2	30.2	28.3	26.9	25.4	24.2	23.1	22	21	20.1	19.3
54	34.6	32.2	30.2	28.3	26.8	25.4	24.2	23	21.9	21	20.1	19.3
55	34.6	32.1	30.1	28.3	26.8	25.4	24.1	23	21.9	21	20.1	19.3
56	34.5	32.1	30.1	28.3	26.8	25.3	24.1	23	21.9	21	20.1	19.3
57	34.4	32.1	30.1	28.2	26.8	25.3	24.1	23	21.9	21	20.1	19.3
58	34.4	32	30	28.2	26.7	25.3	24.1	23	21.9	21	20.1	19.3
59	34.3	32	30	28.2	26.7	25.3	24.1	23	21.9	21	20.1	19.3



PIECE-FINDING TABLE — EIGHT HOURS

SHOWING NUMBER OF PIECES WHEN TIME REQUIRED TO
DO ONE PIECE IS OVER ONE MINUTE

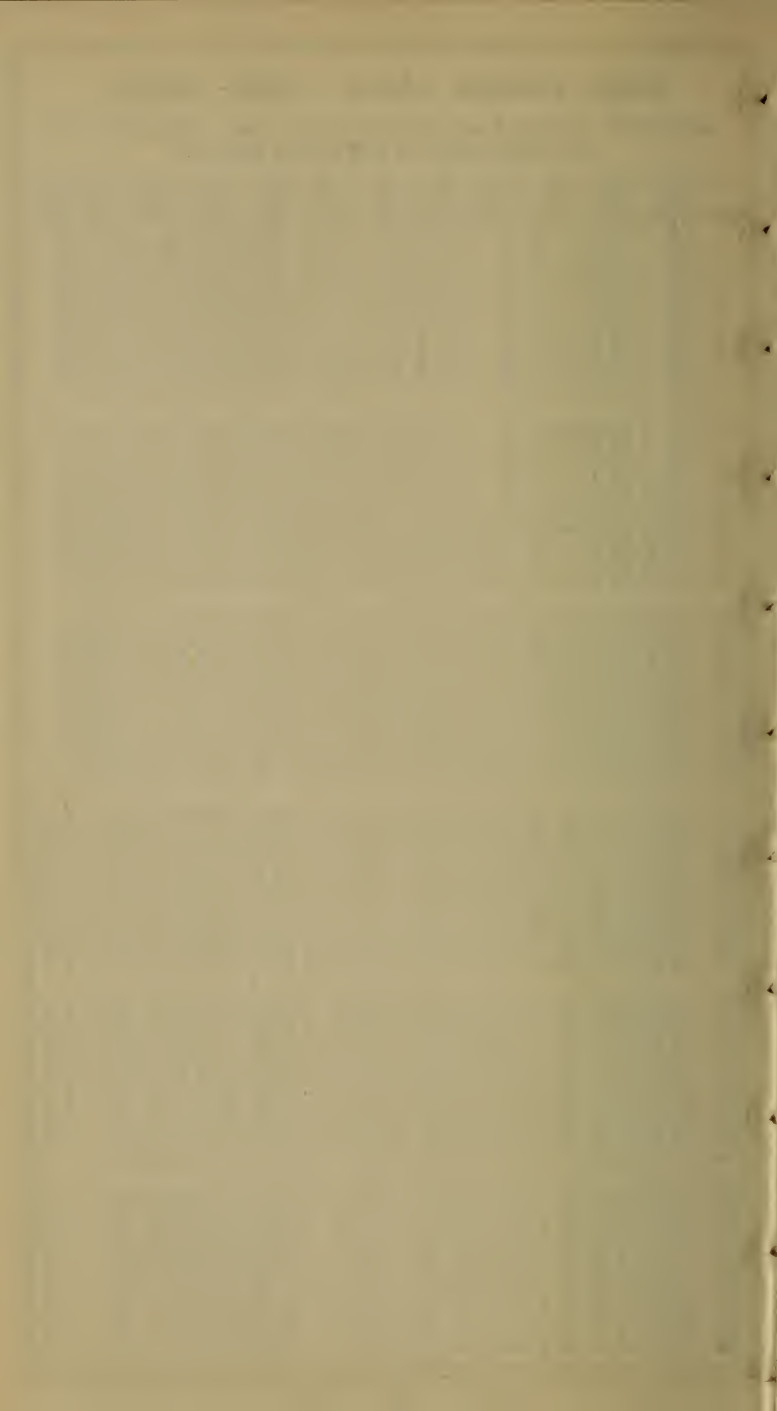
Sec.	25 Min.	26 Min.	27 Min.	28 Min.	29 Min.	30 Min.	31 Min.	32 Min.	33 Min.	34 Min.	35 Min.	36 Min.
1	19.2	18.5	17.8	17.1	16.5	16	15.5	15	14.5	14.1	13.7	13.3
2	19.2	18.5	17.8	17.1	16.5	16	15.5	15	14.5	14.1	13.7	13.3
3	19.2	18.5	17.8	17.1	16.5	16	15.5	15	14.5	14.1	13.7	13.3
4	19.2	18.5	17.8	17.1	16.5	16	15.5	15	14.5	14.1	13.7	13.3
5	19.2	18.5	17.8	17.1	16.5	16	15.5	15	14.5	14.1	13.7	13.3
6	19.2	18.5	17.8	17.1	16.5	16	15.5	15	14.5	14.1	13.7	13.3
7	19.2	18.5	17.8	17.1	16.5	16	15.5	15	14.5	14.1	13.7	13.3
8	19.2	18.4	17.7	17.1	16.5	16	15.5	15	14.5	14.1	13.7	13.3
9	19.1	18.4	17.7	17	16.5	16	15.5	15	14.5	14.1	13.7	13.3
10	19.1	18.4	17.7	17	16.5	16	15.5	15	14.5	14.1	13.7	13.3
11	19.1	18.4	17.7	17	16.4	15.9	15.4	14.9	14.5	14.1	13.7	13.3
12	19.1	18.4	17.7	17	16.4	15.9	15.4	14.9	14.5	14.1	13.7	13.3
13	19.1	18.4	17.7	17	16.4	15.9	15.4	14.9	14.5	14.1	13.7	13.3
14	19.1	18.4	17.7	17	16.4	15.9	15.4	14.9	14.4	14	13.6	13.3
15	19.1	18.4	17.7	17	16.4	15.9	15.4	14.9	14.4	14	13.6	13.3
16	19.1	18.3	17.6	17	16.4	15.9	15.4	14.9	14.4	14	13.6	13.3
17	19.1	18.3	17.6	17	16.4	15.9	15.4	14.9	14.4	14	13.6	13.3
18	19	18.3	17.6	17	16.4	15.9	15.4	14.9	14.4	14	13.6	13.3
19	19	18.3	17.6	16.9	16.4	15.9	15.4	14.9	14.4	14	13.6	13.2
20	19	18.3	17.6	16.9	16.4	15.9	15.4	14.9	14.4	14	13.6	13.2
21	19	18.3	17.6	16.9	16.4	15.9	15.4	14.9	14.4	14	13.6	13.2
22	19	18.3	17.6	16.9	16.4	15.9	15.4	14.9	14.4	14	13.6	13.2
23	19	18.3	17.6	16.9	16.3	15.8	15.3	14.8	14.4	14	13.6	13.2
24	19	18.2	17.5	16.9	16.3	15.8	15.3	14.8	14.4	14	13.6	13.2
25	19	18.2	17.5	16.9	16.3	15.8	15.3	14.8	14.4	14	13.6	13.2
26	19	18.2	17.5	16.9	16.3	15.8	15.3	14.8	14.4	14	13.6	13.2
27	18.9	18.2	17.5	16.9	16.3	15.8	15.3	14.8	14.4	14	13.6	13.2
28	18.9	18.2	17.5	16.9	16.3	15.8	15.3	14.8	14.4	14	13.6	13.2
29	18.9	18.2	17.5	16.8	16.3	15.8	15.3	14.8	14.3	13.9	13.5	13.2
30	18.9	18.2	17.5	16.8	16.3	15.8	15.3	14.8	14.3	13.9	13.5	13.2
31	18.9	18.2	17.5	16.8	16.3	15.8	15.3	14.8	14.3	13.9	13.5	13.2
32	18.9	18.1	17.4	16.8	16.3	15.8	15.3	14.8	14.3	13.9	13.5	13.2
33	18.9	18.1	17.4	16.8	16.3	15.8	15.3	14.8	14.3	13.9	13.5	13.2
34	18.9	18.1	17.4	16.8	16.3	15.8	15.3	14.8	14.3	13.9	13.5	13.2
35	18.9	18.1	17.4	16.8	16.2	15.7	15.2	14.7	14.3	13.9	13.5	13.2
36	18.8	18.1	17.4	16.8	16.2	15.7	15.2	14.7	14.3	13.9	13.5	13.2
37	18.8	18.1	17.4	16.8	16.2	15.7	15.2	14.7	14.3	13.9	13.5	13.2
38	18.8	18.1	17.4	16.8	16.2	15.7	15.2	14.7	14.3	13.9	13.5	13.2
39	18.8	18.1	17.4	16.7	16.2	15.7	15.2	14.7	14.3	13.9	13.5	13.1
40	18.8	18	17.3	16.7	16.2	15.7	15.2	14.7	14.3	13.9	13.5	13.1
41	18.8	18	17.3	16.7	16.2	15.7	15.2	14.7	14.3	13.9	13.5	13.1
42	18.8	18	17.3	16.7	16.2	15.7	15.2	14.7	14.3	13.9	13.5	13.1
43	18.8	18	17.3	16.7	16.2	15.7	15.2	14.7	14.3	13.9	13.5	13.1
44	18.8	18	17.3	16.7	16.2	15.7	15.2	14.7	14.2	13.8	13.4	13.1
45	18.7	18	17.3	16.7	16.2	15.7	15.2	14.7	14.2	13.8	13.4	13.1
46	18.7	18	17.3	16.7	16.2	15.7	15.2	14.7	14.2	13.8	13.4	13.1
47	18.7	18	17.3	16.7	16.1	15.6	15.1	14.6	14.2	13.8	13.4	13.1
48	18.7	18	17.3	16.7	16.1	15.6	15.1	14.6	14.2	13.8	13.4	13.1
49	18.7	17.9	17.2	16.6	16.1	15.6	15.1	14.6	14.2	13.8	13.4	13.1
50	18.7	17.9	17.2	16.6	16.1	15.6	15.1	14.6	14.2	13.8	13.4	13.1
51	18.7	17.9	17.2	16.6	16.1	15.6	15.1	14.6	14.2	13.8	13.4	13.1
52	18.6	17.9	17.2	16.6	16.1	15.6	15.1	14.6	14.2	13.8	13.4	13.1
53	18.6	17.9	17.2	16.6	16.1	15.6	15.1	14.6	14.2	13.8	13.4	13.1
54	18.6	17.9	17.2	16.6	16.1	15.6	15.1	14.6	14.2	13.8	13.4	13.1
55	18.6	17.9	17.2	16.6	16.1	15.6	15.1	14.6	14.2	13.8	13.4	13.1
56	18.6	17.9	17.2	16.6	16.1	15.6	15.1	14.6	14.2	13.8	13.4	13.1
57	18.6	17.9	17.2	16.6	16.1	15.6	15.1	14.6	14.2	13.8	13.4	13.1
58	18.6	17.9	17.2	16.6	16.1	15.6	15.1	14.6	14.2	13.8	13.4	13.1
59	18.6	17.9	17.2	16.6	16.1	15.6	15.1	14.6	14.2	13.8	13.4	13.1



PIECE-FINDING TABLE — EIGHT HOURS

SHOWING NUMBER OF PIECES WHEN TIME REQUIRED TO
DO ONE PIECE IS OVER ONE MINUTE

Sec.	37 Min.	38 Min.	39 Min.	40 Min.	41 Min.	42 Min.	43 Min.	44 Min.	45 Min.	46 Min.	47 Min.	48 Min.
1	13	12.6	12.3	12	11.6	11.4	11.2	10.9	10.7	10.4	10.2	10
2	13	12.6	12.3	12	11.6	11.4	11.2	10.9	10.7	10.4	10.2	10
3	13	12.6	12.3	12	11.6	11.4	11.2	10.9	10.7	10.4	10.2	10
4	13	12.6	12.3	12	11.6	11.4	11.2	10.9	10.7	10.4	10.2	10
5	13	12.6	12.3	12	11.6	11.4	11.2	10.9	10.7	10.4	10.2	10
6	13	12.6	12.3	12	11.6	11.4	11.2	10.9	10.7	10.4	10.2	10
7	13	12.6	12.3	12	11.6	11.4	11.2	10.9	10.7	10.4	10.2	10
8	13	12.6	12.3	12	11.6	11.4	11.2	10.9	10.7	10.4	10.2	10
9	13	12.6	12.3	12	11.6	11.4	11.2	10.9	10.7	10.4	10.2	10
10	13	12.6	12.3	12	11.6	11.4	11.2	10.9	10.7	10.4	10.2	10
11	13	12.6	12.3	12	11.6	11.4	11.2	10.9	10.7	10.4	10.2	10
12	13	12.6	12.3	12	11.6	11.4	11.2	10.9	10.7	10.4	10.2	10
13	13	12.6	12.3	12	11.6	11.4	11.2	10.9	10.7	10.4	10.2	10
14	12.9	12.6	12.3	12	11.6	11.4	11.2	10.9	10.7	10.4	10.2	10
15	12.9	12.6	12.3	11.9	11.6	11.4	11.2	10.9	10.7	10.4	10.2	10
16	12.9	12.6	12.3	11.9	11.6	11.4	11.2	10.9	10.7	10.4	10.2	10
17	12.9	12.6	12.3	11.9	11.6	11.4	11.2	10.9	10.7	10.4	10.2	10
18	12.9	12.6	12.3	11.9	11.6	11.4	11.2	10.9	10.7	10.4	10.2	10
19	12.9	12.6	12.3	11.9	11.6	11.4	11.2	10.9	10.7	10.4	10.2	10
20	12.9	12.5	12.2	11.9	11.6	11.4	11.1	10.9	10.6	10.4	10.2	10
21	12.9	12.5	12.2	11.9	11.6	11.4	11.1	11.9	10.6	10.4	10.2	10
22	12.9	12.5	12.2	11.9	11.6	11.4	11.1	10.9	10.6	10.4	10.2	10
23	12.9	12.5	12.2	11.9	11.6	11.4	11.1	10.9	10.6	10.4	10.2	10
24	12.9	12.5	12.2	11.9	11.6	11.4	11.1	10.9	10.6	10.4	10.2	10
25	12.9	12.5	12.2	11.9	11.6	11.4	11.1	10.9	10.6	10.4	10.2	10
26	12.9	12.5	12.2	11.9	11.6	11.4	11.1	10.9	10.6	10.4	10.2	10
27	12.9	12.5	12.2	11.9	11.6	11.4	11.1	10.9	10.6	10.4	10.2	10
28	12.9	12.5	12.2	11.9	11.6	11.4	11.1	10.9	10.6	10.4	10.2	10
29	12.8	12.5	12.2	11.9	11.6	11.4	11.1	10.9	10.6	10.4	10.2	10
30	12.8	12.5	12.2	11.8	11.5	11.3	11.1	10.8	10.6	10.3	10.1	9.9
31	12.8	12.5	12.2	11.8	11.5	11.3	11.1	10.8	10.6	10.3	10.1	9.9
32	12.8	12.5	12.2	11.8	11.5	11.3	11.1	10.8	10.6	10.3	10.1	9.9
33	12.8	12.5	12.2	11.8	11.5	11.3	11.1	10.8	10.6	10.3	10.1	9.9
34	12.8	12.5	12.2	11.8	11.5	11.3	11.1	10.8	10.6	10.3	10.1	9.9
35	12.8	12.5	12.2	11.8	11.5	11.3	11.1	10.8	10.6	10.3	10.1	9.9
36	12.8	12.5	12.2	11.8	11.5	11.3	11.1	10.8	10.6	10.3	10.1	9.9
37	12.8	12.5	12.2	11.8	11.5	11.3	11.1	10.8	10.6	10.3	10.1	9.9
38	12.8	12.5	12.2	11.8	11.5	11.3	11.1	10.8	10.6	10.3	10.1	9.9
39	12.8	12.5	12.2	11.8	11.5	11.3	11.1	10.8	10.6	10.3	10.1	9.9
40	12.8	12.4	12.1	11.8	11.5	11.3	11	10.8	10.5	10.3	10.1	9.9
41	12.8	12.4	12.1	11.8	11.5	11.3	11	10.8	10.5	10.3	10.1	9.9
42	12.8	12.4	12.1	11.8	11.5	11.3	11	10.8	10.5	10.3	10.1	9.9
43	12.8	12.4	12.1	11.8	11.5	11.3	11	10.8	10.5	10.3	10.1	9.9
44	12.7	12.4	12.1	11.8	11.5	11.3	11	10.8	10.5	10.3	10.1	9.9
45	12.7	12.4	12.1	11.7	11.5	11.3	11	10.8	10.5	10.3	10.1	9.9
46	12.7	12.4	12.1	11.7	11.5	11.3	11	10.8	10.5	10.3	10.1	9.9
47	12.7	12.4	12.1	11.7	11.5	11.3	11	10.8	10.5	10.3	10.1	9.9
48	12.7	12.4	12.1	11.7	11.5	11.3	11	10.8	10.5	10.3	10.1	9.9
49	12.7	12.4	12.1	11.7	11.5	11.3	11	10.8	10.5	10.3	10.1	9.9
50	12.7	12.4	12.1	11.7	11.5	11.3	11	10.8	10.5	10.3	10.1	9.9
51	12.7	12.4	12.1	11.7	11.5	11.3	11	10.8	10.5	10.3	10.1	9.9
52	12.7	12.4	12.1	11.7	11.5	11.3	11	10.8	10.5	10.3	10.1	9.9
53	12.7	12.4	12.1	11.7	11.5	11.3	11	10.8	10.5	10.3	10.1	9.9
54	12.7	12.4	12.1	11.7	11.5	11.3	11	10.8	10.5	10.3	10.1	9.9
55	12.7	12.4	12.1	11.7	11.5	11.3	11	10.8	10.5	10.3	10.1	9.9
56	12.7	12.4	12.1	11.7	11.5	11.3	11	10.8	10.5	10.3	10.1	9.9
57	12.7	12.4	12.1	11.7	11.5	11.3	11	10.8	10.5	10.3	10.1	9.9
58	12.7	12.4	12.1	11.7	11.5	11.3	11	10.8	10.5	10.3	10.1	9.9
59	12.7	12.4	12.1	11.7	11.5	11.3	11	10.8	10.5	10.3	10.1	9.9



PIECE-FINDING TABLE — EIGHT HOURS

SHOWING NUMBER OF PIECES WHEN TIME REQUIRED TO
DO ONE PIECE IS OVER ONE MINUTE

Sec.	49 Min.	50 Min.	51 Min.	52 Min.	53 Min.	54 Min.	55 Min.	56 Min.	57 Min.	58 Min.	59 Min.
1	9.8	9.6	9.4	9.2	9.1	8.9	8.7	8.6	8.4	8.3	8.1
2	9.8	9.6	9.4	9.2	9.1	8.9	8.7	8.6	8.4	8.3	8.1
3	9.8	9.6	9.4	9.2	9.1	8.9	8.7	8.6	8.4	8.3	8.1
4	9.8	9.6	9.4	9.2	9.1	8.9	8.7	8.6	8.4	8.3	8.1
5	9.8	9.6	9.4	9.2	9.1	8.9	8.7	8.6	8.4	8.3	8.1
6	9.8	9.6	9.4	9.2	9.1	8.9	8.7	8.6	8.4	8.3	8.1
7	9.8	9.6	9.4	9.2	9.1	8.9	8.7	8.6	8.4	8.3	8.1
8	9.8	9.6	9.4	9.2	9.1	8.9	8.7	8.6	8.4	8.3	8.1
9	9.8	9.6	9.4	9.2	9.1	8.9	8.7	8.6	8.4	8.3	8.1
10	9.8	9.6	9.4	9.2	9.1	8.9	8.7	8.6	8.4	8.3	8.1
11	9.8	9.6	9.4	9.2	9.1	8.9	8.7	8.6	8.4	8.3	8.1
12	9.8	9.6	9.4	9.2	9.1	8.9	8.7	8.6	8.4	8.3	8.1
13	9.8	9.6	9.4	9.2	9.1	8.9	8.7	8.6	8.4	8.3	8.1
14	9.8	9.6	9.4	9.2	9.1	8.9	8.7	8.6	8.4	8.3	8.1
15	9.8	9.6	9.4	9.2	9.1	8.9	8.7	8.6	8.4	8.3	8.1
16	9.8	9.6	9.4	9.2	9.1	8.9	8.7	8.6	8.4	8.3	8.1
17	9.8	9.6	9.4	9.2	9.1	8.9	8.7	8.6	8.4	8.3	8.1
18	9.8	9.6	9.4	9.2	9.1	8.9	8.7	8.6	8.4	8.3	8.1
19	9.8	9.6	9.4	9.2	9.1	8.9	8.7	8.6	8.4	8.3	8.1
20	9.8	9.6	9.4	9.2	9.1	8.9	8.7	8.6	8.4	8.3	8.1
21	9.8	9.6	9.4	9.2	9.1	8.9	8.7	8.6	8.4	8.3	8.1
22	9.8	9.6	9.4	9.2	9.1	8.9	8.7	8.6	8.4	8.3	8.1
23	9.8	9.6	9.4	9.2	9.1	8.9	8.7	8.6	8.4	8.3	8.1
24	9.8	9.6	9.4	9.2	9.1	8.9	8.7	8.6	8.4	8.3	8.1
25	9.8	9.6	9.4	9.2	9.1	8.9	8.7	8.6	8.4	8.3	8.1
26	9.8	9.6	9.4	9.2	9.1	8.9	8.7	8.6	8.4	8.3	8.1
27	9.8	9.6	9.4	9.2	9.1	8.9	8.7	8.6	8.4	8.3	8.1
28	9.8	9.6	9.4	9.2	9.1	8.9	8.7	8.6	8.4	8.3	8.1
29	9.8	9.6	9.4	9.2	9.1	8.9	8.7	8.6	8.4	8.3	8.1
30	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8.1
31	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8.1
32	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8.1
33	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8.1
34	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8.1
35	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8.1
36	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8.1
37	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8.1
38	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8.1
39	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8.1
40	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8.1
41	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8.1
42	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8.1
43	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8.1
44	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8.1
45	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8.1
46	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8.1
47	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8.1
48	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8.1
49	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8.1
50	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8.1
51	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8.1
52	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8.1
53	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8.1
54	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8.1
55	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8.1
56	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8.1
57	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8.1
58	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8.1
59	9.7	9.5	9.3	9.1	9	8.8	8.7	8.5	8.4	8.3	8

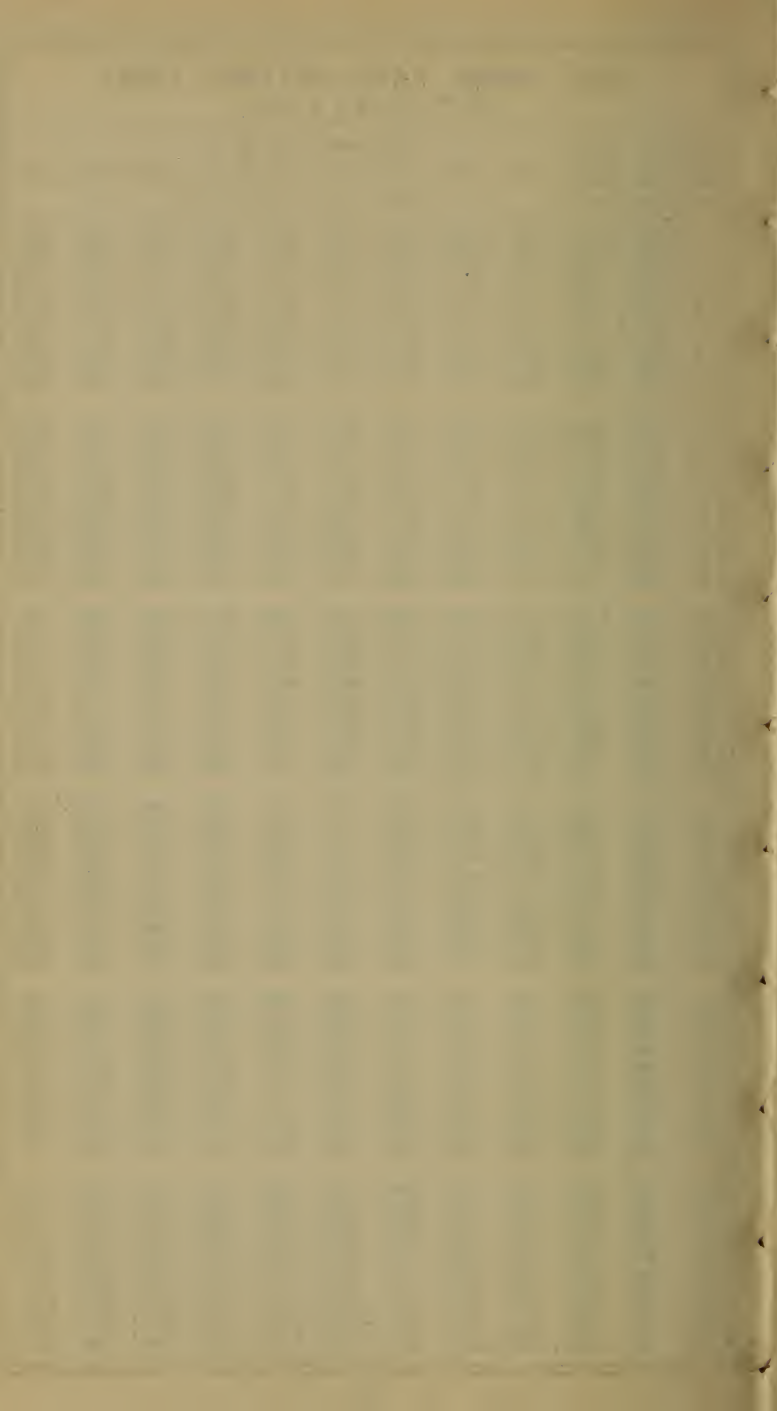
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Dr. M. P. Howell	41479 Poplar St.	Chicago	Ill.
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Dr. S. V. Baker	43291 Oak St.	Chicago	Ill.
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Dr. U. X. Evans	43895 Cedar St.	Chicago	Ill.
Dr. V. Y. Fisher	44197 Birch St.	Chicago	Ill.
Dr. W. Z. Gibson	44499 Spruce St.	Chicago	Ill.
Dr. X. A. Howell	44801 Ash St.	Chicago	Ill.
Dr. Y. B. Ingram	45103 Willow St.	Chicago	Ill.
Dr. Z. C. Jones	45405 Hickory St.	Chicago	Ill.
Dr. A. D. King	45707 Poplar St.	Chicago	Ill.
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Dr. L. O. King	49029 Ash St.	Chicago	Ill.
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Dr. O. R. Baker	49935 Poplar St.	Chicago	Ill.
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Dr. V. Y. Jones	52049 Pine St.	Chicago	Ill.
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Dr. X. A. Scott	52653 Birch St.	Chicago	Ill.
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Dr. Z. C. Baker	53257 Ash St.	Chicago	Ill.
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Dr. B. E. Evans	53861 Hickory St.	Chicago	Ill.
Dr. C. F. Fisher	54163 Poplar St.	Chicago	Ill.
Dr. D. G. Gibson	54465 Sycamore St.	Chicago	Ill.
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Dr. F. I. Ingram	55069 Walnut St.	Chicago	Ill.
Dr. G. J. Jones	55371 Elm St.	Chicago	Ill.
Dr. H. K. King	55673 Maple St.	Chicago	Ill.
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Dr. N. Q. Fisher	57485 Ash St.	Chicago	Ill.
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Dr. P. S. Howell	58089 Hickory St.	Chicago	Ill.
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Dr. T. W. Scott	59297 Walnut St.	Chicago	Ill.
Dr. U. X. Adams	59599 Elm St.	Chicago	Ill.
Dr. V. Y. Baker	59901 Maple St.	Chicago	Ill.
Dr. W. Z. Clark	60203 Oak St.	Chicago	Ill.
Dr. X. A. Evans	60505 Pine St.	Chicago	Ill.
Dr. Y. B. Fisher	60807 Cedar St.	Chicago	Ill.
Dr. Z. C. Gibson	61109 Birch St.	Chicago	Ill.
Dr. A. D. Howell	61411 Spruce St.	Chicago	Ill.
Dr. B. E. Ingram	61713 Ash St.	Chicago	Ill.
Dr. C. F. Jones	62015 Willow St.	Chicago	Ill.
Dr. D. G. King	62317 Hickory St.	Chicago	Ill.
Dr. E. H. Scott	62619 Poplar St.	Chicago	Ill.
Dr. F. I. Adams	62921 Sycamore St.	Chicago	Ill.
Dr. G. J. Baker	63223 Chestnut St.	Chicago	Ill.
Dr. H. K. Clark	63525 Walnut St.	Chicago	Ill.
Dr. I. L. Evans	63827 Elm St.	Chicago	Ill.
Dr. J. M. Fisher	64129 Maple St.	Chicago	Ill.
Dr. K. N. Gibson	64431 Oak St.	Chicago	Ill.
Dr. L. O. Howell	64733 Pine St.	Chicago	Ill.
Dr. M. P. Ingram	65035 Cedar St.	Chicago	Ill.
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Dr. D. G. Scott	85873 Pine St.	Chicago	Ill.
Dr. E. H. Adams	86175 Cedar St.	Chicago	Ill.
Dr. F. I. Baker			

PIECE WORK RATE-SETTING TABLE

EIGHT HOURS A DAY

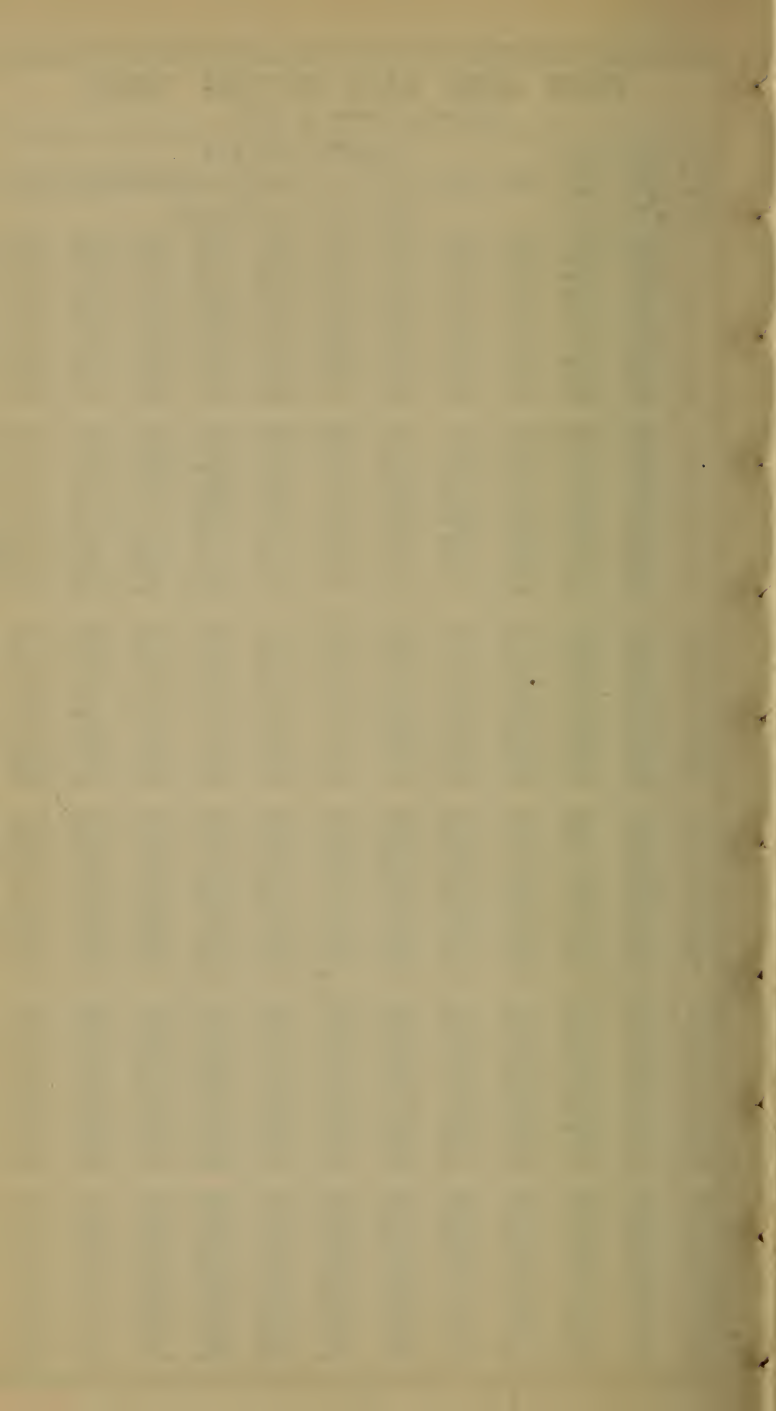
Sec. to do One Piece	No. of Pieces in One Hour	No. of Pieces in Eight Hours	AMOUNT PER DAY								
			.75	.80	.90	1.00	1.10	1.20	1.25	1.30	1.40
			RATE PER 100 PIECES								
1	3600	28800	.0026	.0028	.0031	.0035	.0038	.0042	.0043	.0045	.0049
2	1800	14400	.0052	.0056	.0063	.0069	.0076	.0083	.0087	.0090	.0097
3	1200	9600	.0078	.0083	.0094	.0104	.0115	.0125	.0130	.0135	.0146
4	900	7200	.0104	.0111	.0125	.0139	.0153	.0167	.0174	.0181	.0194
5	720	5760	.0130	.0139	.0156	.0174	.0191	.0208	.0217	.0226	.0243
6	600	4800	.0156	.0167	.0188	.0208	.0229	.0250	.0260	.0271	.0292
7	514	4114	.0182	.0194	.0219	.0243	.0267	.0292	.0304	.0316	.0340
8	450	3600	.0208	.0222	.0250	.0278	.0306	.0333	.0347	.0361	.0389
9	400	3200	.0234	.0250	.0281	.0312	.0344	.0375	.0391	.0406	.0437
10	360	2880	.0260	.0278	.0313	.0347	.0382	.0417	.0434	.0451	.0486
11	327	2618	.0286	.0306	.0344	.0382	.0420	.0458	.0477	.0497	.0535
12	300	2400	.0312	.0333	.0375	.0417	.0458	.0500	.0521	.0542	.0583
13	277	2215	.0339	.0361	.0406	.0451	.0496	.0542	.0564	.0587	.0632
14	257	2057	.0365	.0389	.0438	.0486	.0535	.0583	.0608	.0632	.0680
15	240	1920	.0391	.0417	.0469	.0521	.0573	.0625	.0651	.0677	.0729
16	225	1800	.0417	.0444	.0500	.0556	.0611	.0667	.0694	.0722	.0778
17	212	1694	.0443	.0472	.0531	.0590	.0649	.0708	.0738	.0767	.0826
18	200	1600	.0469	.0500	.0563	.0625	.0687	.0750	.0781	.0813	.0875
19	190	1516	.0495	.0528	.0594	.0660	.0726	.0792	.0825	.0858	.0924
20	180	1440	.0521	.0556	.0625	.0694	.0764	.0833	.0868	.0903	.0972
21	171	1371	.0547	.0582	.0656	.0729	.0802	.0875	.0911	.0948	.1021
22	164	1309	.0573	.0611	.0688	.0764	.0840	.0917	.0955	.0993	.1069
23	157	1252	.0599	.0639	.0719	.0799	.0878	.0958	.0998	.1038	.1118
24	150	1200	.0625	.0667	.0750	.0833	.0917	.1000	.1042	.1083	.1167
25	144	1152	.0651	.0695	.0781	.0868	.0955	.1042	.1085	.1129	.1215
26	138	1107	.0677	.0722	.0813	.0903	.0993	.1083	.1128	.1174	.1264
27	133	1067	.0703	.0750	.0844	.0937	.1031	.1125	.1172	.1219	.1312
28	129	1028	.0729	.0779	.0875	.0972	.1069	.1166	.1215	.1264	.1361
29	124	993	.0755	.0806	.0906	.1007	.1108	.1208	.1259	.1309	.1410
30	120	960	.0781	.0833	.0938	.1042	.1146	.1250	.1302	.1354	.1458
31	116	929	.0807	.0861	.0969	.1076	.1184	.1291	.1345	.1399	.1507
32	112	900	.0833	.0889	.1000	.1111	.1222	.1333	.1389	.1444	.1556
33	109	873	.0859	.0917	.1031	.1146	.1260	.1375	.1432	.1489	.1604
34	106	847	.0885	.0945	.1063	.1180	.1298	.1416	.1476	.1535	.1653
35	103	823	.0911	.0972	.1094	.1215	.1337	.1458	.1519	.1580	.1701
36	100	800	.0937	.1000	.1125	.1250	.1375	.1500	.1562	.1625	.1750
37	97	778	.0963	.1028	.1156	.1285	.1413	.1541	.1606	.1670	.1799
38	95	758	.0990	.1056	.1188	.1319	.1451	.1583	.1649	.1715	.1847
39	92	738	.1016	.1083	.1219	.1354	.1489	.1625	.1693	.1760	.1896
40	90	720	.1042	.1111	.1250	.1389	.1528	.1666	.1736	.1806	.1944
41	88	702	.1068	.1139	.1281	.1425	.1566	.1708	.1779	.1851	.1993
42	86	685	.1094	.1167	.1313	.1458	.1604	.1750	.1823	.1896	.2042
43	84	669	.1120	.1195	.1344	.1492	.1642	.1791	.1866	.1941	.2090
44	82	654	.1146	.1222	.1375	.1528	.1680	.1833	.1910	.1986	.2139
45	80	640	.1172	.1250	.1406	.1562	.1719	.1875	.1953	.2031	.2187
46	78	626	.1198	.1278	.1438	.1597	.1757	.1916	.1996	.2076	.2236
47	76	613	.1224	.1306	.1469	.1632	.1795	.1958	.2040	.2122	.2285
48	75	600	.1250	.1333	.1500	.1667	.1833	.2000	.2083	.2167	.2333
49	73	587	.1276	.1361	.1531	.1701	.1871	.2041	.2127	.2212	.2382
50	72	576	.1302	.1389	.1563	.1736	.1910	.2083	.2170	.2257	.2431
51	71	565	.1328	.1417	.1594	.1771	.1948	.2125	.2213	.2302	.2479
52	69	553	.1354	.1445	.1625	.1805	.1986	.2166	.2257	.2347	.2528
53	68	543	.1380	.1472	.1656	.1840	.2024	.2208	.2300	.2392	.2576
54	67	533	.1406	.1500	.1688	.1875	.2062	.2250	.2344	.2438	.2625
55	65	524	.1432	.1528	.1719	.1910	.2100	.2291	.2387	.2483	.2674
56	64	514	.1458	.1556	.1750	.1944	.2139	.2333	.2430	.2528	.2722
57	63	505	.1484	.1583	.1781	.1979	.2177	.2375	.2474	.2572	.2771
58	62	496	.1510	.1611	.1813	.2014	.2215	.2416	.2517	.2618	.2819
59	61	488	.1536	.1639	.1844	.2048	.2253	.2458	.2561	.2663	.2868
60	60	480	.1562	.1667	.1875	.2083	.2291	.2499	.2604	.2708	.2917



PIECE WORK RATE-SETTING TABLE

EIGHT HOURS A DAY

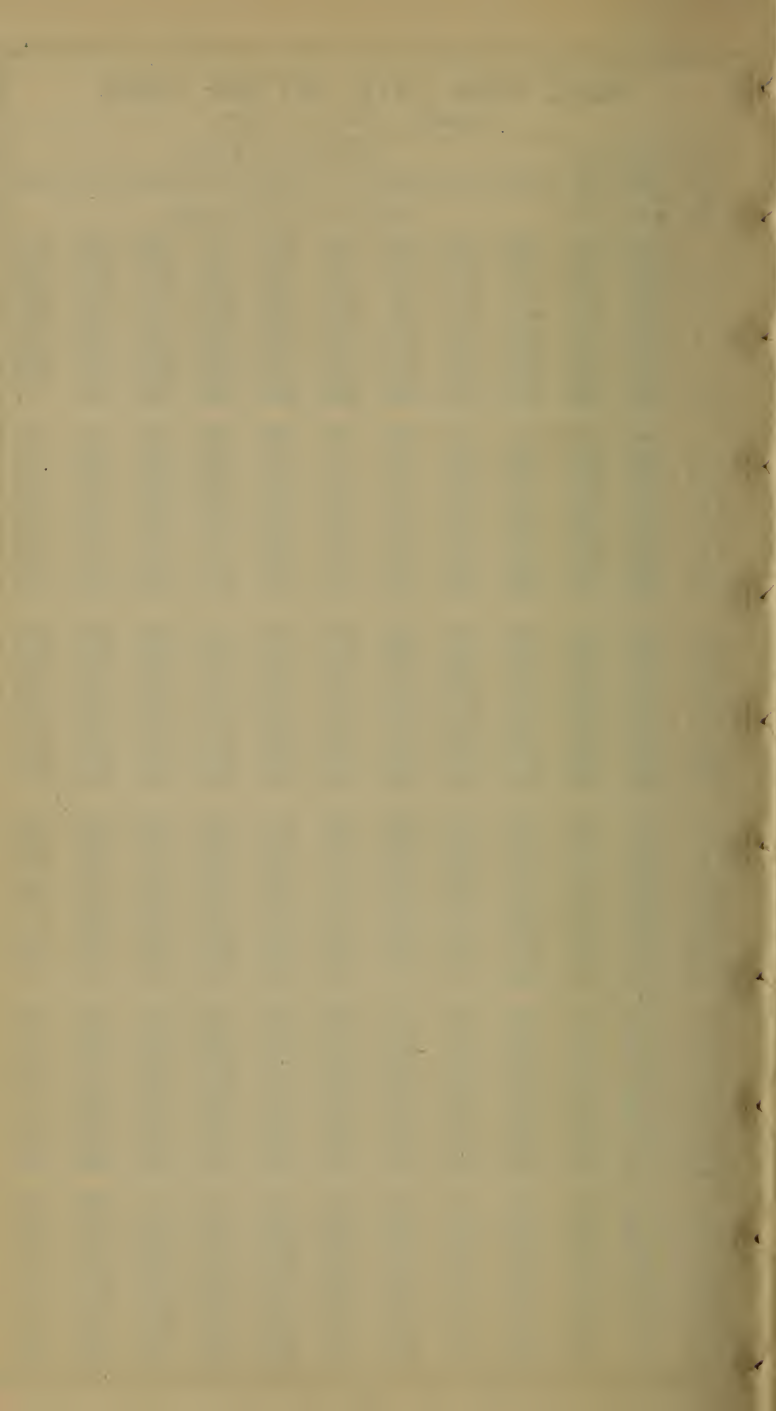
Sec. to do One Piece	No. of Pieces in One Hour	No. of Pieces in Eight Hours	AMOUNT PER DAY								
			1.50	1.60	1.70	1.75	1.80	1.90	2.00	2.10	2.25
			RATE PER 100 PIECES								
1	3600	28800	.0052	.0056	.0059	.0061	.0063	.0066	.0069	.0073	.0078
2	1800	14400	.0104	.0111	.0118	.0122	.0125	.0132	.0139	.0146	.0156
3	1200	9600	.0156	.0167	.0177	.0182	.0188	.0198	.0208	.0219	.0234
4	900	7200	.0208	.0222	.0236	.0243	.0250	.0264	.0278	.0292	.0312
5	720	5760	.0260	.0278	.0295	.0304	.0313	.0330	.0347	.0365	.0391
6	600	4800	.0312	.0333	.0354	.0365	.0375	.0396	.0417	.0437	.0469
7	514	4114	.0365	.0389	.0413	.0425	.0438	.0462	.0486	.0510	.0547
8	450	3600	.0417	.0444	.0472	.0486	.0500	.0528	.0555	.0583	.0625
9	400	3200	.0469	.0500	.0531	.0547	.0563	.0594	.0625	.0656	.0703
10	360	2880	.0521	.0556	.0590	.0608	.0625	.0660	.0694	.0729	.0781
11	327	2618	.0573	.0611	.0649	.0668	.0688	.0726	.0764	.0802	.0859
12	300	2400	.0625	.0667	.0708	.0729	.0750	.0792	.0833	.0875	.0937
13	277	2215	.0677	.0722	.0767	.0790	.0813	.0858	.0903	.0948	.1016
14	257	2057	.0729	.0778	.0826	.0851	.0875	.0924	.0972	.1021	.1094
15	240	1920	.0781	.0833	.0885	.0911	.0938	.0990	.1042	.1094	.1171
16	225	1800	.0833	.0889	.0944	.0972	.1000	.1056	.1111	.1167	.1250
17	212	1694	.0885	.0944	.1003	.1033	.1063	.1121	.1180	.1239	.1328
18	200	1600	.0937	.1000	.1062	.1094	.1125	.1187	.1250	.1312	.1406
19	190	1516	.0990	.1055	.1121	.1154	.1188	.1253	.1319	.1385	.1484
20	180	1440	.1042	.1111	.1180	.1215	.1250	.1319	.1389	.1458	.1562
21	171	1371	.1094	.1167	.1239	.1276	.1313	.1385	.1458	.1531	.1641
22	164	1309	.1146	.1222	.1298	.1337	.1375	.1451	.1528	.1604	.1719
23	157	1252	.1198	.1278	.1357	.1397	.1438	.1517	.1597	.1677	.1797
24	150	1200	.1250	.1333	.1416	.1458	.1500	.1583	.1667	.1750	.1875
25	144	1152	.1302	.1389	.1476	.1519	.1563	.1649	.1736	.1823	.1953
26	138	1107	.1354	.1444	.1535	.1580	.1625	.1715	.1805	.1896	.2031
27	133	1067	.1406	.1500	.1594	.1641	.1688	.1781	.1875	.1969	.2109
28	129	1028	.1458	.1555	.1653	.1701	.1750	.1847	.1944	.2041	.2187
29	124	993	.1510	.1611	.1712	.1762	.1813	.1913	.2014	.2114	.2265
30	120	960	.1562	.1667	.1771	.1823	.1875	.1979	.2083	.2187	.2344
31	116	929	.1614	.1722	.1830	.1884	.1938	.2045	.2153	.2260	.2422
32	112	900	.1667	.1778	.1889	.1944	.2000	.2111	.2222	.2333	.2500
33	109	873	.1719	.1833	.1948	.2005	.2063	.2177	.2292	.2406	.2578
34	106	847	.1771	.1889	.2007	.2066	.2125	.2243	.2361	.2478	.2656
35	103	823	.1823	.1944	.2066	.2127	.2188	.2309	.2430	.2552	.2734
36	100	800	.1875	.2000	.2125	.2187	.2250	.2375	.2500	.2625	.2812
37	97	778	.1927	.2055	.2184	.2248	.2313	.2441	.2569	.2698	.2890
38	95	758	.1979	.2111	.2243	.2309	.2375	.2507	.2639	.2771	.2969
39	92	738	.2031	.2166	.2302	.2370	.2438	.2573	.2708	.2843	.3047
40	90	720	.2083	.2222	.2361	.2430	.2500	.2639	.2778	.2916	.3125
41	88	702	.2135	.2278	.2420	.2491	.2563	.2705	.2847	.2989	.3203
42	86	685	.2187	.2333	.2479	.2552	.2625	.2771	.2916	.3062	.3281
43	84	669	.2239	.2389	.2538	.2613	.2688	.2837	.2986	.3135	.3359
44	82	654	.2292	.2444	.2597	.2673	.2750	.2903	.3055	.3208	.3437
45	80	640	.2344	.2500	.2656	.2734	.2813	.2969	.3125	.3281	.3515
46	78	626	.2396	.2555	.2715	.2795	.2875	.3035	.3194	.3354	.3594
47	76	613	.2448	.2611	.2774	.2856	.2938	.3101	.3264	.3427	.3672
48	75	600	.2500	.2666	.2833	.2916	.3000	.3167	.3333	.3500	.3750
49	73	587	.2552	.2722	.2892	.2977	.3063	.3233	.3403	.3573	.3828
50	72	576	.2604	.2778	.2951	.3038	.3125	.3299	.3472	.3646	.3906
51	71	565	.2656	.2833	.3010	.3099	.3188	.3364	.3541	.3718	.3984
52	69	553	.2708	.2889	.3069	.3160	.3250	.3430	.3611	.3792	.4062
53	68	543	.2760	.2944	.3128	.3220	.3313	.3496	.3680	.3864	.4140
54	67	533	.2812	.3000	.3187	.3281	.3375	.3562	.3750	.3937	.4218
55	65	524	.2864	.3055	.3246	.3342	.3438	.3628	.3819	.4010	.4297
56	64	514	.2916	.3111	.3305	.3403	.3500	.3694	.3889	.4083	.4375
57	63	505	.2969	.3166	.3364	.3463	.3563	.3760	.3958	.4156	.4453
58	62	496	.3021	.3222	.3423	.3524	.3625	.3826	.4028	.4229	.4531
59	61	488	.3073	.3277	.3482	.3585	.3688	.3892	.4097	.4302	.4609
60	60	480	.3125	.3333	.3541	.3646	.3750	.3958	.4166	.4375	.4687



PIECE WORK RATE - SETTING TABLE

EIGHT HOURS A DAY

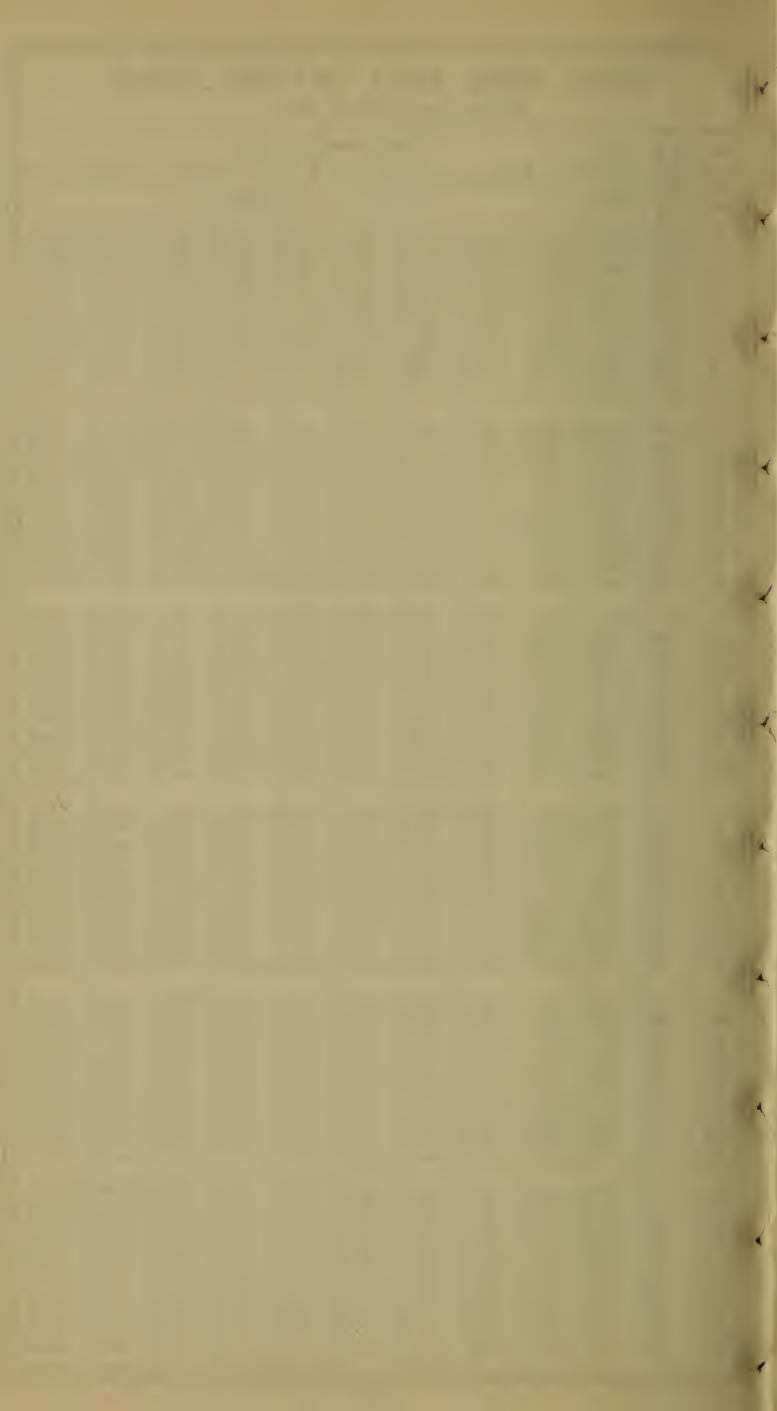
Sec. to do One Piece	No. of Pieces in One Hour	No. of Pieces in Eight Hours	AMOUNT PER DAY									
			2.40	2.50	2.60	2.75	2.80	2.90	3.00	3.10	3.20	
			RATE PER 100 PIECES									
1	3600	28800	.0083	.0087	.0090	.0096	.0097	.0101	.0104	.0108	.0111	
2	1800	14400	.0167	.0174	.0181	.0191	.0194	.0201	.0208	.0215	.0222	
3	1200	9600	.0250	.0260	.0271	.0287	.0292	.0302	.0312	.0323	.0333	
4	900	7200	.0333	.0347	.0361	.0382	.0389	.0403	.0417	.0431	.0444	
5	720	5760	.0417	.0434	.0451	.0478	.0486	.0503	.0521	.0538	.0556	
6	600	4800	.0500	.0521	.0541	.0574	.0583	.0604	.0625	.0646	.0667	
7	514	4114	.0583	.0608	.0632	.0669	.0681	.0705	.0729	.0753	.0778	
8	450	3600	.0667	.0694	.0722	.0765	.0778	.0806	.0833	.0861	.0889	
9	400	3200	.0750	.0781	.0812	.0861	.0875	.0906	.0937	.0969	.1000	
10	360	2880	.0833	.0868	.0903	.0956	.0972	.1007	.1042	.1076	.1111	
11	327	2618	.0917	.0955	.0993	.1052	.1069	.1108	.1146	.1184	.1222	
12	300	2400	.1000	.1042	.1083	.1147	.1167	.1208	.1250	.1292	.1333	
13	277	2215	.1083	.1128	.1174	.1243	.1264	.1309	.1354	.1399	.1444	
14	257	2057	.1167	.1215	.1264	.1339	.1361	.1410	.1458	.1507	.1555	
15	240	1920	.1250	.1302	.1354	.1434	.1458	.1510	.1562	.1614	.1667	
16	225	1800	.1333	.1389	.1444	.1530	.1556	.1611	.1667	.1722	.1778	
17	212	1694	.1417	.1476	.1535	.1626	.1653	.1712	.1771	.1830	.1889	
18	200	1600	.1500	.1562	.1625	.1721	.1750	.1812	.1875	.1937	.2000	
19	190	1516	.1583	.1649	.1715	.1817	.1847	.1913	.1979	.2045	.2111	
20	180	1440	.1667	.1736	.1805	.1912	.1944	.2014	.2083	.2153	.2222	
21	171	1371	.1750	.1823	.1896	.2008	.2042	.2114	.2187	.2260	.2333	
22	164	1309	.1833	.1910	.1986	.2104	.2139	.2215	.2292	.2368	.2444	
23	157	1252	.1917	.1996	.2076	.2199	.2236	.2316	.2396	.2475	.2555	
24	150	1200	.2000	.2083	.2166	.2295	.2333	.2417	.2500	.2583	.2666	
25	144	1152	.2083	.2170	.2257	.2391	.2431	.2517	.2604	.2691	.2778	
26	138	1107	.2167	.2257	.2347	.2486	.2528	.2618	.2708	.2798	.2889	
27	133	1067	.2250	.2344	.2437	.2582	.2625	.2719	.2812	.2906	.3000	
28	129	1028	.2333	.2430	.2528	.2677	.2722	.2819	.2916	.3014	.3111	
29	124	993	.2417	.2517	.2618	.2773	.2819	.2920	.3021	.3121	.3222	
30	120	960	.2500	.2604	.2708	.2869	.2917	.3021	.3125	.3229	.3333	
31	116	929	.2583	.2691	.2798	.2964	.3014	.3121	.3229	.3337	.3444	
32	112	900	.2667	.2778	.2889	.3060	.3111	.3222	.3333	.3444	.3555	
33	109	873	.2750	.2864	.2979	.3155	.3208	.3323	.3437	.3552	.3666	
34	106	847	.2833	.2951	.3069	.3251	.3305	.3423	.3541	.3659	.3777	
35	103	823	.2917	.3038	.3159	.3347	.3403	.3524	.3646	.3767	.3889	
36	100	800	.3000	.3125	.3250	.3442	.3500	.3625	.3750	.3875	.4000	
37	97	778	.3083	.3212	.3340	.3538	.3597	.3726	.3854	.3983	.4111	
38	95	758	.3167	.3298	.3430	.3634	.3694	.3826	.3958	.4090	.4222	
39	92	738	.3250	.3385	.3521	.3729	.3792	.3927	.4062	.4198	.4333	
40	90	720	.3333	.3472	.3611	.3825	.3889	.4028	.4166	.4305	.4444	
41	88	702	.3417	.3559	.3701	.3920	.3986	.4128	.4271	.4413	.4555	
42	86	685	.3500	.3646	.3791	.4016	.4083	.4229	.4375	.4520	.4666	
43	84	669	.3583	.3732	.3882	.4112	.4180	.4330	.4479	.4628	.4777	
44	82	654	.3667	.3819	.3972	.4207	.4278	.4430	.4583	.4736	.4888	
45	80	640	.3750	.3906	.4062	.4303	.4375	.4531	.4687	.4843	.5000	
46	78	626	.3833	.3993	.4152	.4399	.4472	.4632	.4791	.4951	.5111	
47	76	613	.3917	.4080	.4243	.4494	.4569	.4732	.4896	.5059	.5222	
48	75	600	.4000	.4166	.4333	.4590	.4667	.4833	.5000	.5166	.5333	
49	73	587	.4083	.4253	.4423	.4685	.4764	.4934	.5104	.5274	.5444	
50	72	576	.4167	.4340	.4514	.4781	.4861	.5035	.5208	.5382	.5555	
51	71	565	.4250	.4427	.4604	.4877	.4958	.5135	.5312	.5489	.5666	
52	69	553	.4333	.4514	.4694	.4972	.5055	.5236	.5416	.5597	.5777	
53	68	543	.4416	.4600	.4784	.5068	.5153	.5337	.5520	.5704	.5888	
54	67	533	.4500	.4687	.4875	.5163	.5250	.5437	.5625	.5812	.6000	
55	65	524	.4583	.4774	.4965	.5259	.5348	.5538	.5729	.5920	.6111	
56	64	514	.4666	.4861	.5055	.5355	.5444	.5639	.5833	.6027	.6222	
57	63	505	.4750	.4948	.5145	.5450	.5542	.5739	.5937	.6135	.6333	
58	62	496	.4833	.5034	.5236	.5546	.5639	.5840	.6041	.6243	.6444	
59	61	488	.4916	.5121	.5326	.5642	.5736	.5941	.6145	.6350	.6555	
60	60	480	.5000	.5208	.5416	.5737	.5833	.6041	.6250	.6458	.6666	



PIECE WORK RATE-SETTING TABLE

EIGHT HOURS A DAY

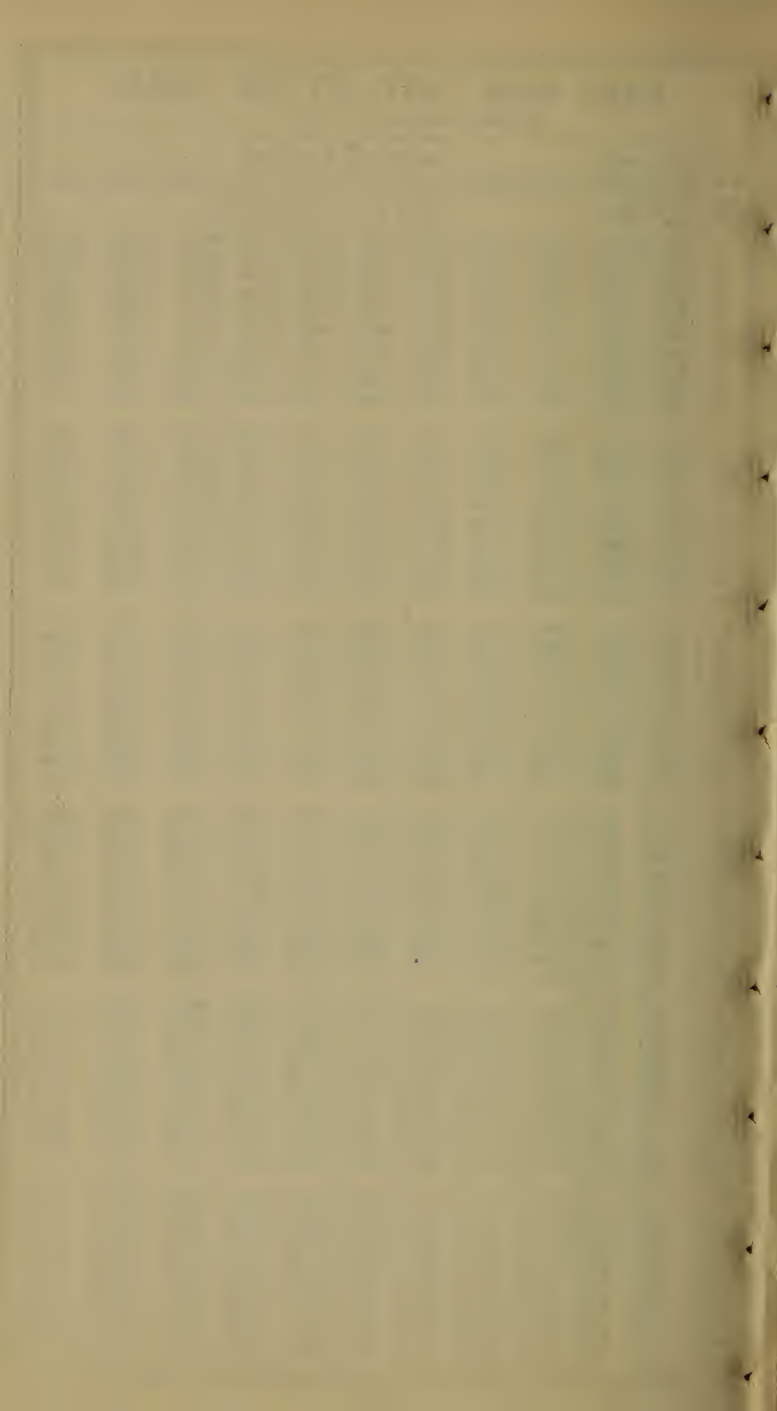
Sec. to do One Piece	No. of Pieces in One Hour	No. of Pieces in Eight Hours	AMOUNT PER DAY								
			3.30	3.40	3.50	3.60	3.70	3.80	3.90	4.00	4.10
			RATE PER 100 PIECES								
1	3600	28800	.0115	.0118	.0122	.0125	.0128	.0132	.0135	.0139	.0142
2	1800	14400	.0229	.0236	.0243	.0250	.0257	.0264	.0271	.0278	.0285
3	1200	9600	.0344	.0354	.0365	.0375	.0385	.0396	.0406	.0417	.0427
4	900	7200	.0458	.0472	.0486	.0500	.0514	.0528	.0542	.0555	.0569
5	720	5760	.0573	.0590	.0608	.0625	.0642	.0660	.0677	.0694	.0712
6	600	4800	.0687	.0708	.0729	.0750	.0771	.0792	.0812	.0833	.0854
7	514	4114	.0802	.0826	.0851	.0875	.0899	.0923	.0948	.0972	.0996
8	450	3600	.0917	.0944	.0972	.1000	.1028	.1055	.1083	.1111	.1139
9	400	3200	.1031	.1062	.1094	.1125	.1156	.1187	.1219	.1250	.1281
10	360	2880	.1146	.1180	.1215	.1250	.1285	.1319	.1354	.1389	.1423
11	327	2618	.1260	.1298	.1337	.1375	.1413	.1451	.1489	.1527	.1566
12	300	2400	.1375	.1416	.1458	.1500	.1541	.1583	.1625	.1666	.1708
13	277	2215	.1489	.1535	.1580	.1625	.1670	.1715	.1760	.1805	.1850
14	257	2057	.1604	.1653	.1701	.1750	.1798	.1847	.1895	.1944	.1993
15	240	1920	.1719	.1771	.1823	.1875	.1927	.1979	.2031	.2083	.2135
16	225	1800	.1833	.1889	.1944	.1990	.2055	.2111	.2166	.2222	.2277
17	212	1694	.1948	.2007	.2066	.2125	.2184	.2243	.2302	.2361	.2420
18	200	1600	.2062	.2125	.2187	.2250	.2312	.2375	.2437	.2499	.2562
19	190	1516	.2177	.2243	.2309	.2375	.2441	.2506	.2573	.2638	.2704
20	180	1440	.2291	.2361	.2430	.2500	.2569	.2638	.2708	.2777	.2847
21	171	1371	.2406	.2479	.2552	.2625	.2697	.2770	.2843	.2916	.2989
22	164	1309	.2521	.2596	.2673	.2750	.2826	.2902	.2979	.3055	.3131
23	157	1252	.2635	.2715	.2795	.2875	.2954	.3034	.3114	.3194	.3274
24	150	1200	.2750	.2833	.2916	.3000	.3083	.3166	.3249	.3333	.3416
25	144	1152	.2864	.2951	.3038	.3125	.3211	.3298	.3385	.3472	.3558
26	138	1107	.2979	.3069	.3159	.3250	.3340	.3430	.3520	.3610	.3701
27	133	1067	.3093	.3187	.3281	.3375	.3468	.3563	.3656	.3749	.3843
28	129	1028	.3208	.3305	.3402	.3500	.3597	.3694	.3791	.3888	.3985
29	124	993	.3323	.3423	.3524	.3625	.3725	.3826	.3926	.4027	.4128
30	120	960	.3437	.3541	.3645	.3749	.3854	.3958	.4062	.4166	.4270
31	116	929	.3552	.3659	.3767	.3874	.3982	.4090	.4197	.4305	.4412
32	112	900	.3666	.3777	.3888	.3999	.4110	.4221	.4332	.4444	.4555
33	109	873	.3781	.3895	.4010	.4124	.4239	.4353	.4468	.4582	.4697
34	106	847	.3895	.4013	.4131	.4249	.4367	.4485	.4603	.4721	.4839
35	103	823	.4010	.4131	.4253	.4374	.4496	.4617	.4739	.4860	.4982
36	100	800	.4125	.4249	.4374	.4499	.4624	.4749	.4874	.4999	.5124
37	97	778	.4239	.4367	.4496	.4624	.4753	.4881	.5009	.5138	.5266
38	95	758	.4354	.4486	.4617	.4749	.4881	.5013	.5145	.5277	.5409
39	92	738	.4468	.4604	.4739	.4874	.5010	.5145	.5280	.5416	.5551
40	90	720	.4583	.4722	.4860	.4999	.5138	.5277	.5416	.5554	.5693
41	88	702	.4697	.4840	.4982	.5124	.5266	.5409	.5551	.5693	.5836
42	86	685	.4812	.4958	.5103	.5249	.5395	.5541	.5686	.5832	.5978
43	84	669	.4927	.5076	.5225	.5374	.5523	.5673	.5822	.5971	.6120
44	82	654	.5041	.5194	.5346	.5499	.5652	.5804	.5957	.6110	.6263
45	80	640	.5156	.5312	.5468	.5624	.5780	.5936	.6093	.6249	.6405
46	78	626	.5270	.5430	.5589	.5749	.5909	.6068	.6228	.6388	.6547
47	76	613	.5385	.5548	.5711	.5874	.6037	.6200	.6363	.6526	.6690
48	75	600	.5499	.5666	.5832	.5999	.6166	.6332	.6499	.6665	.6832
49	73	587	.5614	.5784	.5954	.6124	.6294	.6464	.6634	.6804	.6974
50	72	576	.5729	.5902	.6076	.6249	.6423	.6596	.6770	.6943	.7117
51	71	565	.5843	.6020	.6197	.6374	.6551	.6728	.6905	.7082	.7259
52	69	553	.5958	.6138	.6319	.6499	.6679	.6860	.7040	.7221	.7401
53	68	543	.6072	.6256	.6440	.6624	.6808	.6992	.7175	.7360	.7543
54	67	533	.6187	.6374	.6562	.6749	.6936	.7124	.7311	.7498	.7686
55	65	524	.6301	.6492	.6683	.6874	.7065	.7256	.7446	.7637	.7828
56	64	514	.6416	.6610	.6805	.6999	.7193	.7388	.7585	.7776	.7970
57	63	505	.6530	.6728	.6926	.7124	.7322	.7519	.7717	.7915	.8113
58	62	496	.6645	.6846	.7048	.7249	.7450	.7651	.7853	.8054	.8255
59	61	488	.6760	.6964	.7169	.7374	.7579	.7783	.7988	.8193	.8397
60	60	480	.6874	.7082	.7291	.7499	.7707	.7915	.8123	.8332	.8540



PIECE WORK RATE-SETTING TABLE

EIGHT HOURS A DAY

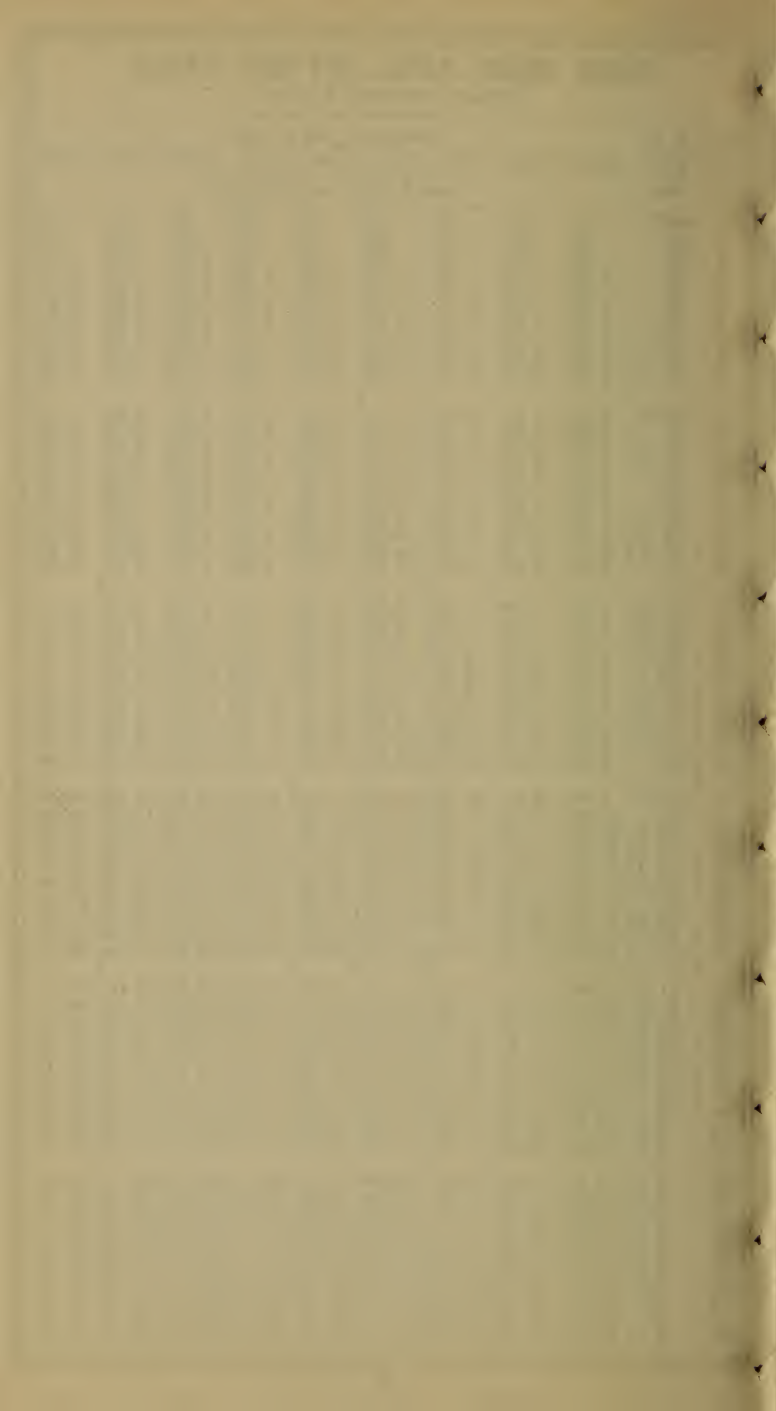
Sec. to do One Piece	No. of Pieces in One Hour	No. of Pieces in Eight Hours	AMOUNT PER DAY								
			4.20	4.30	4.40	4.50	4.60	4.70	4.80	4.90	5.00
			RATE PER 100 PIECES								
1	3600	28800	.0146	.0149	.0153	.0156	.0160	.0163	.0167	.0170	.0174
2	1800	14400	.0292	.0299	.0305	.0312	.0319	.0326	.0333	.0340	.0347
3	1200	9600	.0437	.0448	.0458	.0469	.0479	.0489	.0500	.0510	.0521
4	900	7200	.0583	.0597	.0611	.0625	.0639	.0653	.0667	.0680	.0694
5	720	5760	.0729	.0746	.0764	.0781	.0798	.0816	.0833	.0850	.0868
6	600	4800	.0875	.0896	.0916	.0937	.0958	.0979	.1000	.1021	.1041
7	514	4114	.1021	.1045	.1069	.1093	.1118	.1142	.1166	.1191	.1215
8	450	3600	.1166	.1194	.1222	.1250	.1277	.1305	.1333	.1361	.1388
9	400	3200	.1312	.1343	.1375	.1406	.1437	.1468	.1500	.1531	.1562
10	360	2880	.1458	.1493	.1527	.1562	.1597	.1632	.1666	.1701	.1736
11	327	2618	.1604	.1642	.1680	.1719	.1756	.1795	.1833	.1871	.1909
12	300	2400	.1750	.1791	.1833	.1875	.1916	.1958	.1999	.2041	.2083
13	277	2215	.1895	.1941	.1986	.2031	.2076	.2121	.2166	.2211	.2256
14	257	2057	.2041	.2090	.2138	.2187	.2236	.2284	.2333	.2381	.2430
15	240	1920	.2187	.2239	.2291	.2343	.2395	.2447	.2499	.2551	.2603
16	225	1800	.2333	.2388	.2444	.2499	.2555	.2610	.2666	.2721	.2777
17	212	1694	.2479	.2533	.2597	.2656	.2715	.2774	.2833	.2892	.2951
18	200	1600	.2624	.2687	.2749	.2813	.2874	.2937	.2999	.3062	.3124
19	190	1516	.2770	.2836	.2902	.2968	.3034	.3100	.3166	.3232	.3298
20	180	1440	.2916	.2985	.3055	.3124	.3194	.3263	.3332	.3402	.3471
21	171	1371	.3062	.3135	.3208	.3280	.3353	.3426	.3499	.3572	.3645
22	164	1309	.3208	.3284	.3360	.3437	.3513	.3589	.3666	.3742	.3818
23	157	1252	.3354	.3433	.3513	.3593	.3673	.3752	.3832	.3912	.3992
24	150	1200	.3499	.3582	.3666	.3749	.3832	.3916	.3999	.4082	.4165
25	144	1152	.3645	.3732	.3819	.3905	.3992	.4079	.4166	.4252	.4339
26	138	1107	.3790	.3881	.3971	.4061	.4152	.4242	.4332	.4422	.4513
27	133	1067	.3937	.4030	.4124	.4218	.4311	.4405	.4499	.4592	.4686
28	129	1028	.4082	.4180	.4277	.4374	.4471	.4568	.4665	.4763	.4860
29	124	993	.4228	.4329	.4429	.4530	.4631	.4731	.4832	.4933	.5033
30	120	960	.4374	.4478	.4582	.4686	.4790	.4895	.4999	.5103	.5207
31	116	929	.4520	.4627	.4735	.4843	.4950	.5058	.5165	.5273	.5380
32	112	900	.4666	.4777	.4888	.4999	.5110	.5221	.5331	.5443	.5554
33	109	873	.4811	.4926	.5040	.5155	.5269	.5384	.5498	.5613	.5727
34	106	847	.4957	.5075	.5193	.5311	.5429	.5547	.5665	.5783	.5901
35	103	823	.5103	.5224	.5346	.5467	.5589	.5710	.5832	.5953	.6075
36	100	800	.5249	.5374	.5499	.5624	.5748	.5873	.5998	.6123	.6248
37	97	778	.5395	.5523	.5651	.5780	.5908	.6037	.6165	.6293	.6422
38	95	758	.5540	.5672	.5804	.5936	.6068	.6200	.6332	.6463	.6595
39	92	738	.5686	.5822	.5957	.6092	.6228	.6363	.6498	.6634	.6769
40	90	720	.5832	.5971	.6110	.6248	.6387	.6526	.6665	.6804	.6942
41	88	702	.5978	.6120	.6262	.6405	.6547	.6689	.6831	.6974	.7116
42	86	685	.6124	.6269	.6415	.6561	.6707	.6852	.6998	.7144	.7290
43	84	669	.6269	.6419	.6568	.6717	.6866	.7015	.7165	.7314	.7463
44	82	654	.6415	.6568	.6721	.6873	.7026	.7179	.7331	.7484	.7637
45	80	640	.6561	.6717	.6873	.7029	.7186	.7342	.7498	.7654	.7810
46	78	626	.6707	.6866	.7026	.7186	.7345	.7505	.7665	.7824	.7984
47	76	613	.6853	.7016	.7179	.7342	.7505	.7668	.7831	.7994	.8157
48	75	600	.6998	.7165	.7332	.7498	.7665	.7831	.7998	.8164	.8331
49	73	587	.7144	.7314	.7484	.7654	.7824	.7994	.8164	.8334	.8504
50	72	576	.7290	.7464	.7637	.7811	.7984	.8158	.8331	.8505	.8678
51	71	565	.7436	.7613	.7790	.7967	.8144	.8321	.8498	.8675	.8852
52	69	553	.7582	.7762	.7942	.8123	.8303	.8484	.8664	.8845	.9025
53	68	543	.7727	.7911	.8095	.8279	.8463	.8647	.8831	.9015	.9199
54	67	533	.7873	.8061	.8248	.8435	.8623	.8810	.8997	.9185	.9372
55	65	524	.8019	.8210	.8401	.8592	.8782	.8973	.9164	.9355	.9546
56	64	514	.8165	.8359	.8553	.8748	.8942	.9136	.9331	.9525	.9719
57	63	505	.8311	.8508	.8706	.8904	.9111	.9300	.9497	.9695	.9893
58	62	496	.8456	.8658	.8859	.9060	.9261	.9463	.9664	.9865	1.0066
59	61	488	.8602	.8807	.9012	.9216	.9421	.9626	.9831	1.0035	1.0240
60	60	480	.8748	.8956	.9164	.9373	.9581	.9789	.9997	1.0205	1.0413



PIECE WORK RATE-SETTING TABLE

EIGHT HOURS A DAY

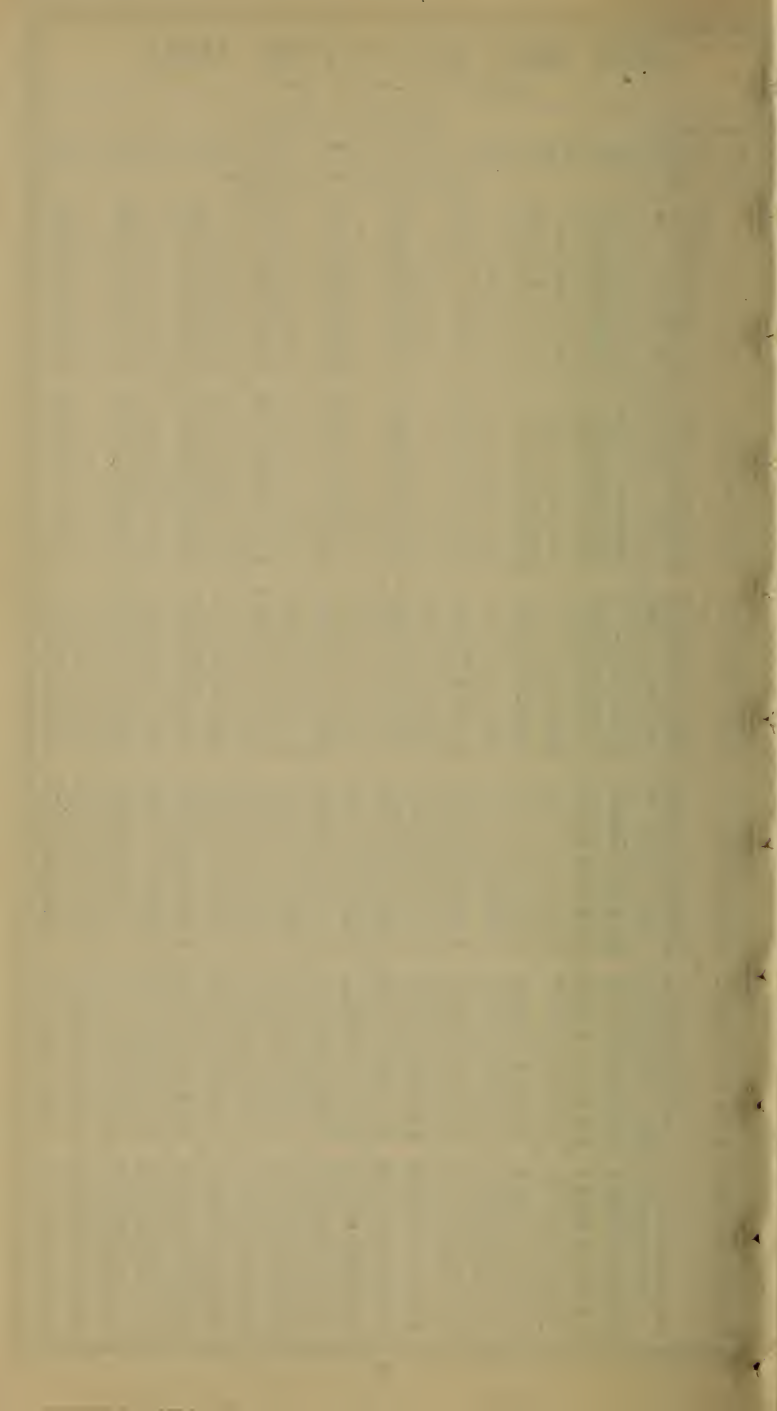
Minutes to do One Piece	No. of Pieces in Eight Hours	AMOUNT PER DAY								
		1.50	1.60	1.70	1.75	1.80	1.90	2.00	2.10	2.25
		RATE PER 100 PIECES								
1	480	.31	.33	.35	.36	.37	.40	.42	.44	.47
2	240	.62	.67	.71	.73	.75	.79	.83	.87	.94
3	160	.94	1.00	1.06	1.09	1.13	1.19	1.25	1.31	1.41
4	120	1.25	1.33	1.42	1.46	1.50	1.58	1.67	1.75	1.87
5	96	1.56	1.67	1.77	1.82	1.88	1.98	2.08	2.19	2.34
6	80	1.87	2.00	2.12	2.19	2.25	2.37	2.50	2.62	2.81
7	68.6	2.19	2.33	2.48	2.55	2.63	2.77	2.92	3.06	3.28
8	60	2.50	2.67	2.83	2.92	3.00	3.17	3.33	3.50	3.75
9	53.3	2.81	3.00	3.19	3.28	3.38	3.56	3.75	3.94	4.22
10	48	3.12	3.33	3.54	3.65	3.75	3.96	4.17	4.37	4.69
11	43.6	3.44	3.67	3.90	4.01	4.13	4.35	4.58	4.81	5.16
12	40	3.75	4.00	4.25	4.37	4.50	4.75	5.00	5.25	5.62
13	37.9	4.06	4.33	4.60	4.74	4.88	5.15	5.42	5.69	6.09
14	34.3	4.37	4.67	4.96	5.10	5.25	5.54	5.83	6.12	6.56
15	32	4.69	5.00	5.31	5.47	5.63	5.94	6.25	6.56	7.03
16	30	5.00	5.33	5.67	5.83	6.00	6.33	6.67	7.00	7.50
17	28.2	5.31	5.67	6.02	6.20	6.38	6.73	7.08	7.44	7.97
18	26.7	5.62	6.00	6.37	6.56	6.75	7.12	7.50	7.87	8.44
19	25.3	5.94	6.33	6.73	6.93	7.13	7.52	7.92	8.31	8.91
20	24	6.25	6.67	7.08	7.29	7.50	7.92	8.33	8.75	9.37
21	22.9	6.56	7.00	7.44	7.66	7.88	8.31	8.75	9.19	9.84
22	21.8	6.87	7.33	7.79	8.02	8.25	8.71	9.17	9.62	10.31
23	20.9	7.19	7.67	8.14	8.38	8.63	9.10	9.58	10.06	10.78
24	20	7.50	8.00	8.59	8.75	9.00	9.50	10.00	10.50	11.25
25	19.2	7.81	8.33	8.85	9.11	9.38	9.90	10.42	10.94	11.72
26	18.5	8.12	8.67	9.21	9.48	9.75	10.29	10.83	11.38	12.19
27	17.8	8.44	9.00	9.56	9.84	10.13	10.69	11.25	11.81	12.66
28	17.1	8.75	9.33	9.92	10.21	10.50	11.08	11.67	12.25	13.12
29	16.5	9.06	9.67	10.27	10.57	10.88	11.48	12.08	12.69	13.59
30	16	9.37	10.00	10.62	10.94	11.25	11.87	12.50	13.12	14.06
31	15.5	9.69	10.33	10.98	11.30	11.63	12.27	12.92	13.56	14.53
32	15	10.00	10.67	11.33	11.67	12.00	12.67	13.33	14.00	15.00
33	14.5	10.31	11.00	11.69	12.03	12.38	13.06	13.75	14.44	15.47
34	14.1	10.62	11.33	12.04	12.40	12.75	13.46	14.17	14.87	15.94
35	13.7	10.94	11.67	12.39	12.76	13.13	13.85	14.58	15.30	16.41
36	13.3	11.25	12.00	12.75	13.12	13.50	14.25	15.00	15.75	16.87
37	13	11.56	12.33	13.10	13.49	13.88	14.65	15.42	16.18	17.34
38	12.6	11.87	12.67	13.46	13.85	14.25	15.04	15.83	16.62	17.81
39	12.3	12.19	13.00	13.81	14.22	14.63	15.44	16.25	17.06	18.28
40	12	12.50	13.33	14.16	14.58	15.00	15.83	16.67	17.50	18.75
41	11.6	12.81	13.67	14.52	14.95	15.38	16.23	17.08	17.93	19.22
42	11.4	13.12	14.00	14.87	15.31	15.75	16.62	17.50	18.37	19.69
43	11.2	13.44	14.32	15.23	15.68	16.13	17.02	17.92	18.81	20.15
44	10.9	13.75	14.67	15.58	16.04	16.50	17.42	18.33	19.25	20.62
45	10.7	14.06	15.00	15.94	16.41	16.88	17.81	18.75	19.69	21.09
46	10.4	14.37	15.33	16.29	16.77	17.25	18.21	19.17	20.12	21.56
47	10.2	14.69	15.67	16.64	17.13	17.63	18.60	19.58	20.56	22.03
48	10	15.00	16.00	17.00	17.50	18.00	19.00	20.00	21.00	22.50
49	9.8	15.31	16.33	17.35	17.86	18.38	19.40	20.42	21.44	22.97
50	9.6	15.62	16.67	17.71	18.23	18.75	19.79	20.83	21.87	23.44
51	9.4	15.93	17.00	18.06	18.59	19.13	20.19	21.25	22.31	23.90
52	9.2	16.25	17.33	18.41	18.96	19.50	20.58	21.67	22.75	24.37
53	9.1	16.56	17.66	18.77	19.32	19.88	20.98	22.08	23.19	24.84
54	8.9	16.87	18.00	19.12	19.69	20.25	21.37	22.50	23.62	25.31
55	8.7	17.19	18.33	19.48	20.05	20.63	21.77	22.92	24.06	25.78
56	8.6	17.50	18.66	19.83	20.42	21.00	22.17	23.33	24.50	26.25
57	8.4	17.81	19.00	20.18	20.78	21.38	22.56	23.75	24.94	26.72
58	8.3	18.12	19.33	20.54	21.14	21.75	22.96	24.17	25.37	27.19
59	8.1	18.44	19.66	20.89	21.51	22.13	23.35	24.58	25.81	27.65
60	8	18.75	20.00	21.25	21.87	22.50	23.75	25.00	26.25	28.12



PIECE WORK RATE-SETTING TABLE

EIGHT HOURS A DAY

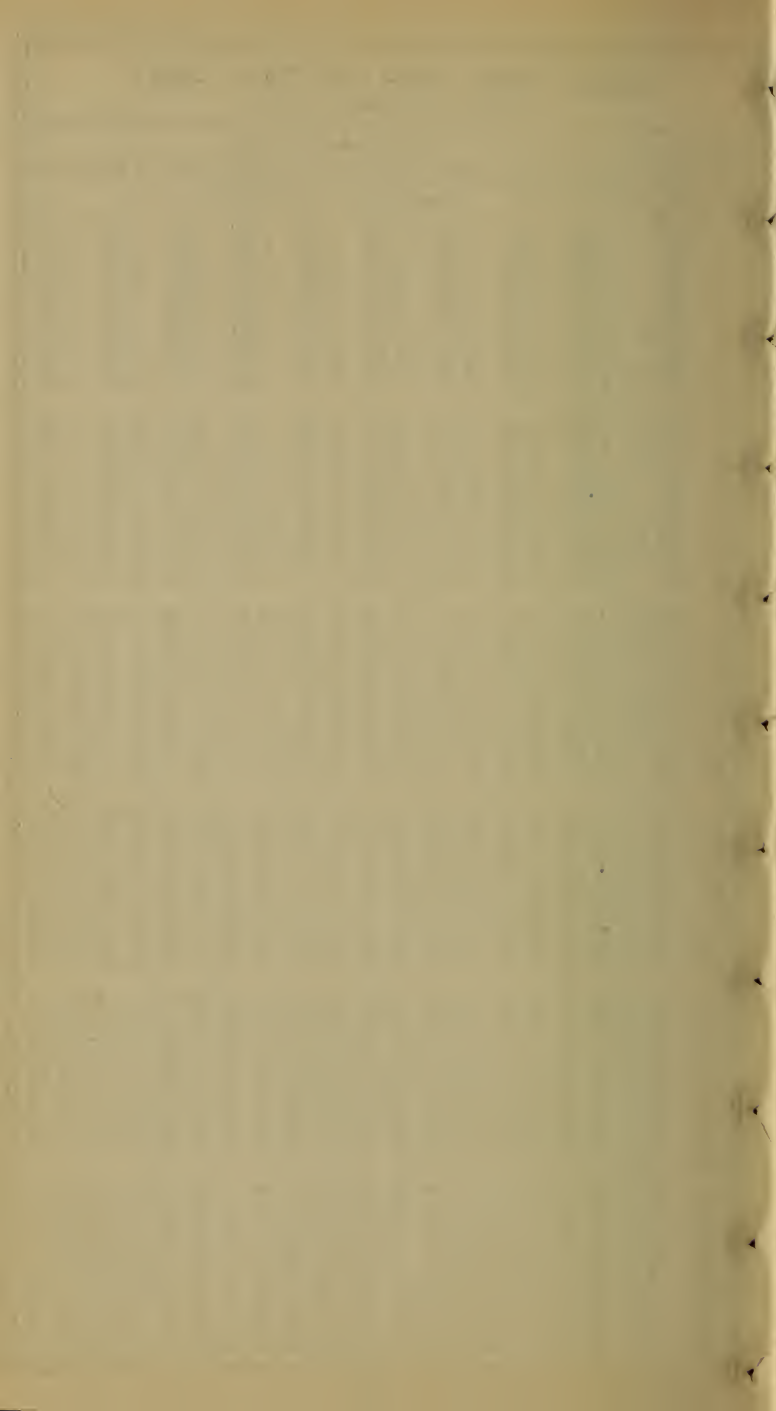
Minutes to do One Piece	No. of Pieces in Eight Hours	AMOUNT PER DAY								
		2.40	2.50	2.60	2.75	2.80	2.90	3.00	3.10	3.20
		RATE PER 100 PIECES								
1	480	.50	.52	.54	.57	.58	.60	.62	.65	.67
2	240	1.00	1.04	1.08	1.15	1.17	1.21	1.25	1.29	1.33
3	160	1.50	1.56	1.62	1.72	1.75	1.81	1.87	1.94	2.00
4	120	2.00	2.08	2.17	2.29	2.33	2.42	2.50	2.58	2.67
5	96	2.50	2.60	2.71	2.87	2.92	3.02	3.12	3.23	3.33
6	80	3.00	3.12	3.25	3.44	3.50	3.62	3.75	3.87	4.00
7	68.6	3.50	3.65	3.79	4.02	4.08	4.23	4.37	4.52	4.67
8	60	4.00	4.17	4.33	4.59	4.67	4.83	5.00	5.17	5.33
9	53.3	4.50	4.69	4.87	5.16	5.25	5.44	5.62	5.81	6.00
10	48	5.00	5.21	5.42	5.74	5.83	6.04	6.25	6.46	6.67
11	43.6	5.50	5.73	5.96	6.31	6.42	6.65	6.87	7.10	7.33
12	40	6.00	6.25	6.50	6.88	7.00	7.25	7.50	7.75	8.00
13	37.9	6.50	6.77	7.04	7.46	7.58	7.85	8.12	8.40	8.67
14	34.3	7.00	7.29	7.58	8.03	8.17	8.46	8.75	9.04	9.33
15	32	7.50	7.81	8.12	8.61	8.75	9.06	9.37	9.69	10.00
16	30	8.00	8.33	8.67	9.18	9.33	9.67	10.00	10.33	10.67
17	28.2	8.50	8.85	9.21	9.75	9.92	10.27	10.62	10.98	11.33
18	26.7	9.00	9.37	9.75	10.33	10.50	10.87	11.25	11.62	12.00
19	25.3	9.50	9.90	10.29	10.90	11.08	11.48	11.87	12.27	12.67
20	24	10.00	10.42	10.83	11.47	11.67	12.08	12.50	12.92	13.33
21	22.9	10.50	10.94	11.37	12.05	12.25	12.69	13.12	13.56	14.00
22	21.8	11.00	11.46	11.92	12.62	12.83	13.29	13.75	14.21	14.67
23	20.9	11.50	11.98	12.46	13.20	13.42	13.90	14.37	14.85	15.33
24	20	12.00	12.50	13.00	13.77	14.00	14.50	15.00	15.50	16.00
25	19.2	12.50	13.02	13.54	14.34	14.58	15.10	15.62	16.14	16.67
26	18.5	13.00	13.54	14.08	14.92	15.17	15.71	16.25	16.79	17.33
27	17.8	13.50	14.06	14.62	15.49	15.75	16.31	16.87	17.44	18.00
28	17.1	14.00	14.58	15.17	16.06	16.33	16.92	17.50	18.08	18.66
29	16.5	14.50	15.10	15.71	16.64	16.92	17.52	18.12	18.73	19.33
30	16	15.00	15.62	16.25	17.21	17.50	18.12	18.75	19.37	20.00
31	15.5	15.50	16.14	16.79	17.79	18.08	18.73	19.37	20.02	20.66
32	15	16.00	16.67	17.33	18.36	18.67	19.33	20.00	20.66	21.33
33	14.5	16.50	17.19	17.87	18.93	19.25	19.94	20.62	21.31	22.00
34	14.1	17.00	17.71	18.42	19.51	19.83	20.54	21.25	21.96	22.66
35	13.7	17.50	18.23	18.96	20.08	20.42	21.14	21.87	22.60	23.33
36	13.3	18.00	18.75	19.50	20.65	21.00	21.75	22.50	23.25	24.00
37	13	18.50	19.27	20.04	21.23	21.58	22.35	23.12	23.89	24.66
38	12.6	19.00	19.79	20.58	21.80	22.17	22.96	23.75	24.54	25.33
39	12.3	19.50	20.31	21.12	22.38	22.75	23.56	24.37	25.19	26.00
40	12	20.00	20.83	21.66	22.95	23.33	24.17	25.00	25.83	26.67
41	11.6	20.50	21.35	22.21	23.52	23.92	24.77	25.62	26.48	27.33
42	11.4	21.00	21.87	22.75	24.10	24.50	25.37	26.25	27.12	28.00
43	11.2	21.50	22.39	23.29	24.67	25.08	25.98	26.87	27.77	28.66
44	10.9	22.00	22.92	23.83	25.24	25.67	26.58	27.50	28.41	29.33
45	10.7	22.50	23.44	24.37	25.82	26.25	27.19	28.12	29.06	30.00
46	10.4	23.00	23.96	24.91	26.39	26.83	27.79	28.75	29.71	30.66
47	10.2	23.50	24.48	25.46	26.96	27.42	28.39	29.37	30.35	31.33
48	10	24.00	25.00	26.00	27.54	28.00	29.00	30.00	31.00	32.00
49	9.8	24.50	25.52	26.54	28.11	28.58	29.60	30.62	31.64	32.66
50	9.6	25.00	26.04	27.08	28.69	29.17	30.21	31.25	32.29	33.33
51	9.4	25.50	26.56	27.62	29.26	29.75	30.81	31.87	32.93	34.00
52	9.2	26.00	27.08	28.16	29.83	30.33	31.42	32.50	33.58	34.66
53	9.1	26.50	27.60	28.71	30.41	30.92	32.02	33.12	34.23	35.33
54	8.9	27.00	28.12	29.25	30.98	31.50	32.63	33.75	34.87	36.00
55	8.7	27.50	28.64	29.79	31.55	32.08	33.23	34.37	35.52	36.66
56	8.6	28.00	29.16	30.33	32.13	32.67	33.83	35.00	36.16	37.33
57	8.4	28.50	29.69	30.87	32.70	33.25	34.44	35.62	36.81	38.00
58	8.3	29.00	30.21	31.41	33.28	33.83	35.04	36.25	37.46	38.66
59	8.1	29.50	30.73	31.96	33.85	34.42	35.64	36.87	38.10	39.33
60	8	30.00	31.25	32.50	34.42	35.00	36.25	37.50	38.75	40.00



PIECE WORK RATE-SETTING TABLE

EIGHT HOURS A DAY

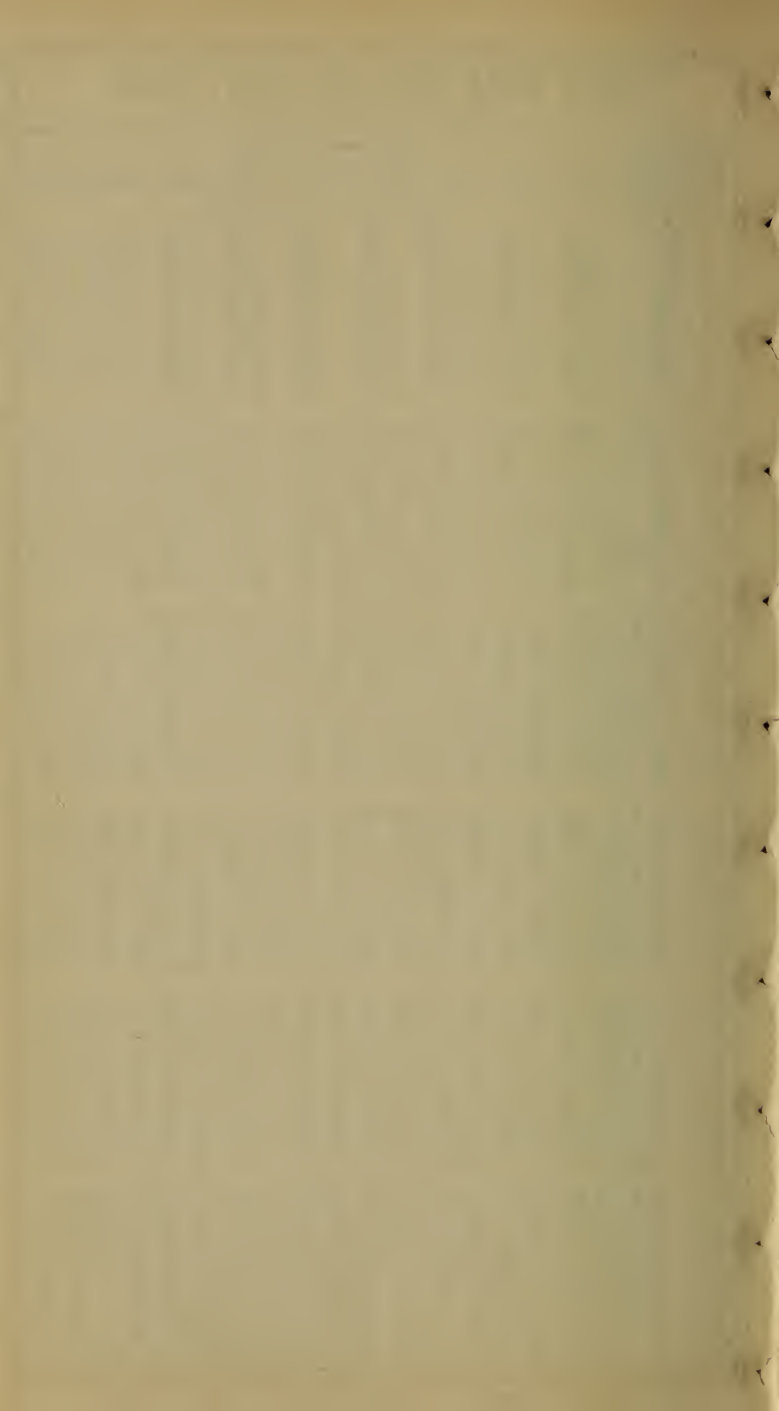
Minutes to do One Piece	No. of Pieces in Eight Hours	AMOUNT PER DAY								
		3.30	3.40	3.50	3.60	3.70	3.80	3.90	4.00	4.10
		RATE PER 100 PIECES								
1	480	.69	.71	.73	.75	.77	.79	.81	.83	.85
2	240	1.37	1.42	1.46	1.50	1.54	1.58	1.62	1.67	1.71
3	160	2.06	2.12	2.19	2.25	2.31	2.37	2.44	2.50	2.56
4	120	2.75	2.83	2.92	3.00	3.08	3.17	3.25	3.33	3.42
5	96	3.44	3.54	3.65	3.75	3.85	3.96	4.06	4.17	4.27
6	80	4.12	4.25	4.37	4.50	4.62	4.75	4.87	5.00	5.12
7	68.6	4.81	4.96	5.10	5.25	5.39	5.54	5.69	5.83	5.98
8	60	5.50	5.67	5.83	6.00	6.17	6.33	6.50	6.67	6.83
9	53.3	6.19	6.37	6.56	6.75	6.94	7.12	7.31	7.50	7.69
10	48	6.87	7.08	7.29	7.50	7.71	7.92	8.12	8.33	8.54
11	43.6	7.56	7.79	8.02	8.25	8.48	8.71	8.94	9.16	9.39
12	40	8.25	8.50	8.75	9.00	9.25	9.50	9.75	10.00	10.25
13	37.9	8.94	9.21	9.48	9.75	10.02	10.29	10.56	10.83	11.10
14	34.3	9.62	9.92	10.21	10.50	10.79	11.08	11.37	11.67	11.96
15	32	10.31	10.62	10.94	11.25	11.56	11.87	12.19	12.50	12.81
16	30	11.00	11.33	11.66	12.00	12.33	12.66	13.00	13.33	13.66
17	28.2	11.69	12.04	12.39	12.75	13.10	13.46	13.81	14.16	14.52
18	26.7	12.37	12.75	13.12	13.50	13.87	14.25	14.62	15.00	15.37
19	25.3	13.06	13.46	13.85	14.25	14.64	15.04	15.43	15.83	16.23
20	24	13.75	14.16	14.58	15.00	15.41	15.83	16.25	16.66	17.08
21	22.9	14.44	14.87	15.31	15.75	16.18	16.62	17.06	17.50	17.93
22	21.8	15.12	15.58	16.04	16.50	16.96	17.41	17.87	18.33	18.79
23	20.9	15.81	16.29	16.76	17.25	17.73	18.20	18.68	19.16	19.64
24	20	16.50	17.00	17.50	18.00	18.50	19.00	19.50	20.00	20.50
25	19.2	17.19	17.71	18.23	18.75	19.27	19.79	20.31	20.83	21.35
26	18.5	17.87	18.41	18.96	19.50	20.04	20.58	21.12	21.66	22.20
27	17.8	18.56	19.12	19.68	20.25	20.81	21.37	21.93	22.50	23.06
28	17.1	19.25	19.83	20.41	21.00	21.58	22.16	22.75	23.33	23.91
29	16.5	19.94	20.54	21.14	21.75	22.35	22.95	23.56	24.16	24.77
30	16	20.62	21.25	21.87	22.50	23.12	23.75	24.37	25.00	25.62
31	15.5	21.31	21.96	22.60	23.25	23.89	24.54	25.18	25.83	26.47
32	15	22.00	22.66	23.33	24.00	24.66	25.33	25.99	26.66	27.33
33	14.5	22.68	23.37	24.06	24.75	25.43	26.12	26.81	27.49	28.18
34	14.1	23.37	24.08	24.79	25.50	26.20	26.91	27.62	28.33	29.04
35	13.7	24.06	24.79	25.52	26.25	26.97	27.70	28.43	29.16	29.89
36	13.3	24.75	25.50	26.25	27.00	27.75	28.49	29.25	29.99	30.74
37	13	25.43	26.20	26.98	27.75	28.52	29.29	30.06	30.83	31.60
38	12.6	26.12	26.91	27.70	28.50	29.29	30.08	30.87	31.66	32.45
39	12.3	26.81	27.62	28.43	29.25	30.06	30.87	31.68	32.49	33.31
40	12	27.50	28.33	29.16	30.00	30.83	31.66	32.49	33.33	34.16
41	11.6	28.18	29.04	29.89	30.75	31.60	32.45	33.31	34.16	35.01
42	11.4	28.87	29.75	30.62	31.49	32.37	33.24	34.12	34.99	35.87
43	11.2	29.56	30.45	31.35	32.24	33.14	34.04	34.93	35.83	36.72
44	10.9	30.25	31.16	32.08	32.99	33.91	34.83	35.74	36.66	37.58
45	10.7	30.93	31.87	32.81	33.74	34.68	35.62	36.56	37.49	38.43
46	10.4	31.62	32.58	33.54	34.49	35.45	36.41	37.37	38.33	39.28
47	10.2	32.31	33.29	34.27	35.24	36.22	37.20	38.18	39.16	40.14
48	10	33.00	34.00	34.99	35.99	36.99	37.99	38.99	39.99	40.99
49	9.8	33.68	34.70	35.72	36.74	37.76	38.78	39.80	40.82	41.85
50	9.6	34.37	35.41	36.45	37.49	38.54	39.58	40.62	41.66	42.70
51	9.4	35.06	36.12	37.18	38.24	39.31	40.37	41.43	42.49	43.55
52	9.2	35.75	36.83	37.91	38.99	40.08	41.16	42.24	43.32	44.41
53	9.1	36.43	37.54	38.64	39.74	40.85	41.95	43.05	44.16	45.26
54	8.9	37.12	38.25	39.37	40.49	41.62	42.74	43.87	44.99	46.11
55	8.7	37.81	38.95	40.10	41.24	42.39	43.53	44.68	45.82	46.97
56	8.6	38.50	39.66	40.83	41.99	43.16	44.33	45.49	46.65	47.82
57	8.4	39.18	40.37	41.56	42.74	43.93	45.12	46.30	47.49	48.68
58	8.3	39.87	41.08	42.29	43.49	44.70	45.91	47.12	48.32	49.53
59	8.1	40.56	41.79	43.01	44.24	45.47	46.70	47.93	49.16	50.38
60	8	41.25	42.49	43.74	44.99	46.24	47.49	48.74	49.99	51.24



PIECE WORK RATE-SETTING TABLE

EIGHT HOURS A DAY

Minutes to do One Piece	No. of Pieces in Eight Hours	AMOUNT PER DAY								
		4.20	4.30	4.40	4.50	4.60	4.70	4.80	4.90	5.00
		RATE PER 100 PIECES								
1	480	.87	.90	.92	.94	.96	.98	1.00	1.02	1.04
2	240	1.75	1.79	1.83	1.87	1.92	1.96	2.00	2.04	2.08
3	160	2.62	2.69	2.75	2.81	2.87	2.94	3.00	3.06	3.12
4	120	3.50	3.58	3.67	3.75	3.83	3.92	4.00	4.08	4.17
5	96	4.37	4.48	4.58	4.69	4.79	4.89	5.00	5.10	5.21
6	80	5.25	5.37	5.50	5.62	5.75	5.87	6.00	6.12	6.25
7	68.6	6.12	6.27	6.42	6.56	6.71	6.85	7.00	7.14	7.29
8	60	7.00	7.16	7.33	7.50	7.66	7.83	8.00	8.16	8.33
9	53.3	7.87	8.06	8.25	8.44	8.62	8.81	9.00	9.18	9.37
10	48	8.75	8.96	9.16	9.37	9.58	9.79	10.00	10.21	10.41
11	43.6	9.62	9.85	10.08	10.31	10.54	10.77	11.00	11.23	11.46
12	40	10.50	10.75	11.00	11.25	11.50	11.75	12.00	12.25	12.50
13	37.9	11.37	11.64	11.91	12.18	12.46	12.73	13.00	13.27	13.54
14	34.3	12.25	12.54	12.83	13.12	13.41	13.70	14.00	14.29	14.58
15	32	13.12	13.43	13.75	14.06	14.37	14.68	15.00	15.31	15.62
16	30	14.00	14.33	14.66	15.00	15.33	15.66	16.00	16.33	16.66
17	28.2	14.87	15.23	15.58	15.93	16.29	16.64	17.00	17.35	17.70
18	26.7	15.75	16.12	16.50	16.87	17.25	17.62	18.00	18.37	18.75
19	25.3	16.62	17.02	17.41	17.81	18.20	18.60	18.99	19.39	19.79
20	24	17.50	17.91	18.33	18.75	19.16	19.58	19.99	20.41	20.83
21	22.9	18.37	18.81	19.25	19.68	20.12	20.56	20.99	21.43	21.87
22	21.8	19.35	19.70	20.16	20.61	21.08	21.54	21.99	22.45	22.91
23	20.9	20.12	20.60	21.08	21.56	22.04	22.51	22.99	23.47	23.95
24	20	21.00	21.49	21.99	22.49	22.99	23.49	23.99	24.49	25.00
25	19.2	21.87	22.39	22.91	23.43	23.95	24.47	24.99	25.51	26.04
26	18.5	22.74	23.29	23.83	24.37	24.91	25.45	25.99	26.53	27.08
27	17.8	23.62	24.18	24.74	25.31	25.87	26.43	26.99	27.55	28.12
28	17.1	24.49	25.08	25.66	26.24	26.83	27.41	27.99	28.58	29.16
29	16.5	25.37	25.97	26.58	27.18	27.78	28.39	28.99	29.60	30.20
30	16	26.24	26.87	27.49	28.12	28.74	29.37	29.99	30.62	31.24
31	15.5	27.12	27.76	28.41	29.06	29.70	30.35	30.99	31.64	32.29
32	15	27.99	28.66	29.33	29.99	30.66	31.32	31.99	32.66	33.33
33	14.5	28.87	29.56	30.24	30.93	31.62	32.30	32.99	33.68	34.37
34	14.1	29.74	30.45	31.16	31.87	32.57	33.28	33.99	34.70	35.41
35	13.7	30.63	31.35	32.08	32.80	33.53	34.26	34.99	35.72	36.45
36	13.3	31.49	32.24	32.99	33.74	34.49	35.24	35.99	36.74	37.49
37	13	32.37	33.14	33.91	34.68	35.45	36.22	36.99	37.76	38.53
38	12.6	33.24	34.03	34.82	35.62	36.41	37.20	37.99	38.78	39.58
39	12.3	34.12	34.93	35.74	36.55	37.37	38.18	38.99	39.80	40.62
40	12	34.99	35.82	36.66	37.49	38.32	39.16	39.99	40.82	41.66
41	11.6	35.87	36.72	37.57	38.43	39.28	40.13	40.99	41.84	42.70
42	11.4	36.74	37.62	38.49	39.36	40.24	41.11	41.99	42.86	43.74
43	11.2	37.62	38.51	39.41	40.30	41.20	42.09	42.99	43.88	44.78
44	10.9	38.49	39.41	40.32	41.24	42.16	43.07	43.99	44.90	45.82
45	10.7	39.37	40.30	41.24	42.18	43.11	44.05	44.99	45.92	46.87
46	10.4	40.24	41.20	42.16	43.11	44.07	45.03	45.99	46.94	47.91
47	10.2	41.12	42.09	43.07	44.05	45.03	46.01	46.99	47.97	48.95
48	10	41.99	42.99	43.99	44.99	45.99	46.99	47.99	48.99	49.99
49	9.8	42.87	43.89	44.91	45.93	46.95	47.97	48.99	50.01	51.03
50	9.6	43.74	44.78	45.82	46.86	47.90	48.95	49.99	51.03	52.07
51	9.4	44.62	45.68	46.74	47.80	48.86	49.92	50.99	52.05	53.11
52	9.2	45.49	46.57	47.65	48.74	49.82	50.90	51.99	53.07	54.16
53	9.1	46.36	47.47	48.57	49.67	50.78	51.88	52.99	54.09	55.20
54	8.9	47.24	48.36	49.49	50.61	51.74	52.86	53.98	55.11	56.24
55	8.7	48.11	49.26	50.40	51.55	52.69	53.84	54.98	56.13	57.28
56	8.6	48.99	50.15	51.32	52.49	53.65	54.82	55.98	57.15	58.32
57	8.4	49.86	51.04	52.24	53.42	54.61	55.79	56.98	58.17	59.36
58	8.3	50.74	51.95	53.15	54.36	55.57	56.78	57.98	59.19	60.40
59	8.1	51.61	52.84	54.07	55.30	56.53	57.76	58.98	60.21	61.45
60	8	52.49	53.74	54.99	56.24	57.48	58.73	59.98	61.23	62.49



PIECE WORK RATE-SETTING TABLE

EIGHT HOURS A DAY

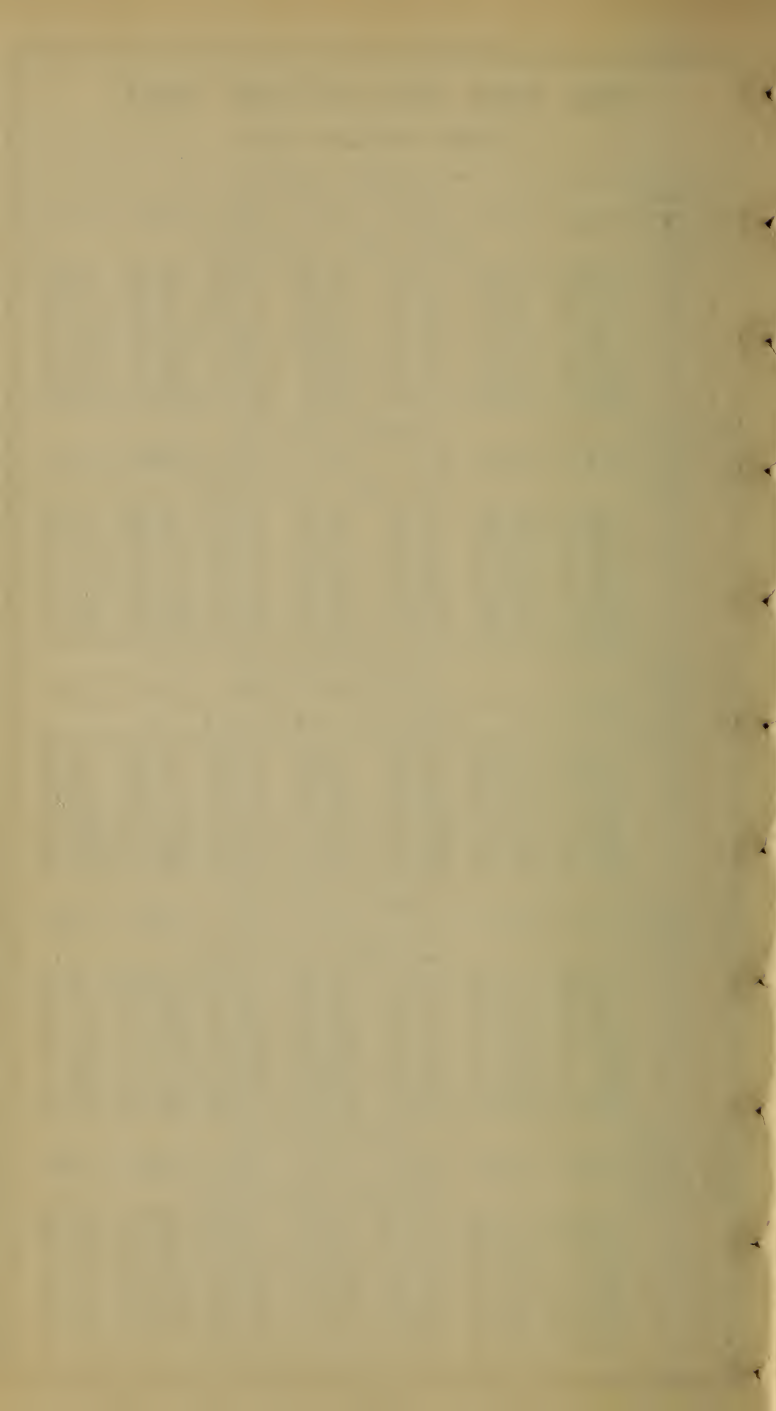
Hours to do One Piece	No. of Pieces in 8 Hours	AMOUNT PER DAY						
		1.50	1.60	1.75	1.80	1.90	2.00	2.10
		RATE PER 100 PIECES						
1	8	18.75	20.00	21.87	22.50	23.75	25.00	26.25
2	4	37.50	40.00	43.74	45.00	47.50	50.00	52.50
3	2 ^{2/3}	56.25	60.00	65.61	67.50	71.25	75.00	78.75
4	2	75.00	80.00	87.48	90.00	95.00	100.00	105.00
5	1 ^{3/4}	93.75	100.00	109.35	112.50	118.75	125.00	131.25
6	1 ^{1/3}	112.50	120.00	131.22	135.00	142.50	150.00	157.50
7	1 ^{1/4}	131.25	140.00	153.09	157.50	166.25	175.00	183.75
8	1	150.00	160.00	175.00	180.00	190.00	200.00	210.00

Hours to do One Piece	No. of Pieces in 8 Hours	AMOUNT PER DAY						
		2.25	2.40	2.50	2.60	2.75	2.80	2.90
		RATE PER 100 PIECES						
1	8	28.12	30.00	31.25	32.50	34.42	35.00	36.25
2	4	56.24	60.00	62.50	65.00	68.84	70.00	72.50
3	2 ^{2/3}	84.36	90.00	93.75	97.50	103.26	105.00	108.75
4	2	112.48	120.00	125.00	130.00	137.68	140.00	145.00
5	1 ^{3/4}	140.60	150.00	155.25	162.50	172.10	175.00	181.25
6	1 ^{1/3}	168.12	180.00	187.50	195.00	206.52	210.00	217.50
7	1 ^{1/4}	196.84	210.00	218.75	227.50	240.94	245.00	253.75
8	1	225.00	240.00	250.00	260.00	275.00	280.00	290.00

Hours to do One Piece	No. of Pieces in 8 Hours	AMOUNT PER DAY						
		3.00	3.10	3.20	3.30	3.40	3.50	3.60
		RATE PER 100 PIECES						
1	8	37.50	38.75	40.00	41.25	42.49	43.74	44.99
2	4	75.00	77.50	80.00	82.50	84.98	87.48	89.98
3	2 ^{2/3}	112.50	116.25	120.00	123.75	127.47	131.22	134.97
4	2	150.00	155.00	160.00	165.00	169.96	174.96	179.96
5	1 ^{3/4}	187.50	193.75	200.00	206.25	212.45	218.70	224.95
6	1 ^{1/3}	225.00	232.50	240.00	247.50	254.94	262.44	269.94
7	1 ^{1/4}	262.50	271.25	280.00	288.75	297.43	306.18	314.93
8	1	300.00	310.00	320.00	330.00	340.00	350.00	360.00

Hours to do One Piece	No. of Pieces in 8 Hours	AMOUNT PER DAY						
		3.70	3.80	3.90	4.00	4.10	4.20	4.30
		RATE PER 100 PIECES						
1	8	46.24	47.49	48.74	49.99	51.24	52.49	53.74
2	4	92.48	94.98	97.48	99.98	102.48	104.98	107.48
3	2 ^{2/3}	138.72	142.47	146.22	149.97	153.72	157.47	161.22
4	2	184.96	189.96	194.96	199.96	204.96	209.96	214.96
5	1 ^{3/4}	231.20	237.45	243.70	249.95	256.20	262.45	268.70
6	1 ^{1/3}	277.44	284.94	292.44	299.94	307.44	314.94	322.44
7	1 ^{1/4}	323.68	332.42	341.18	349.93	358.68	367.43	376.18
8	1	370.00	380.00	390.00	400.00	410.00	420.00	430.00

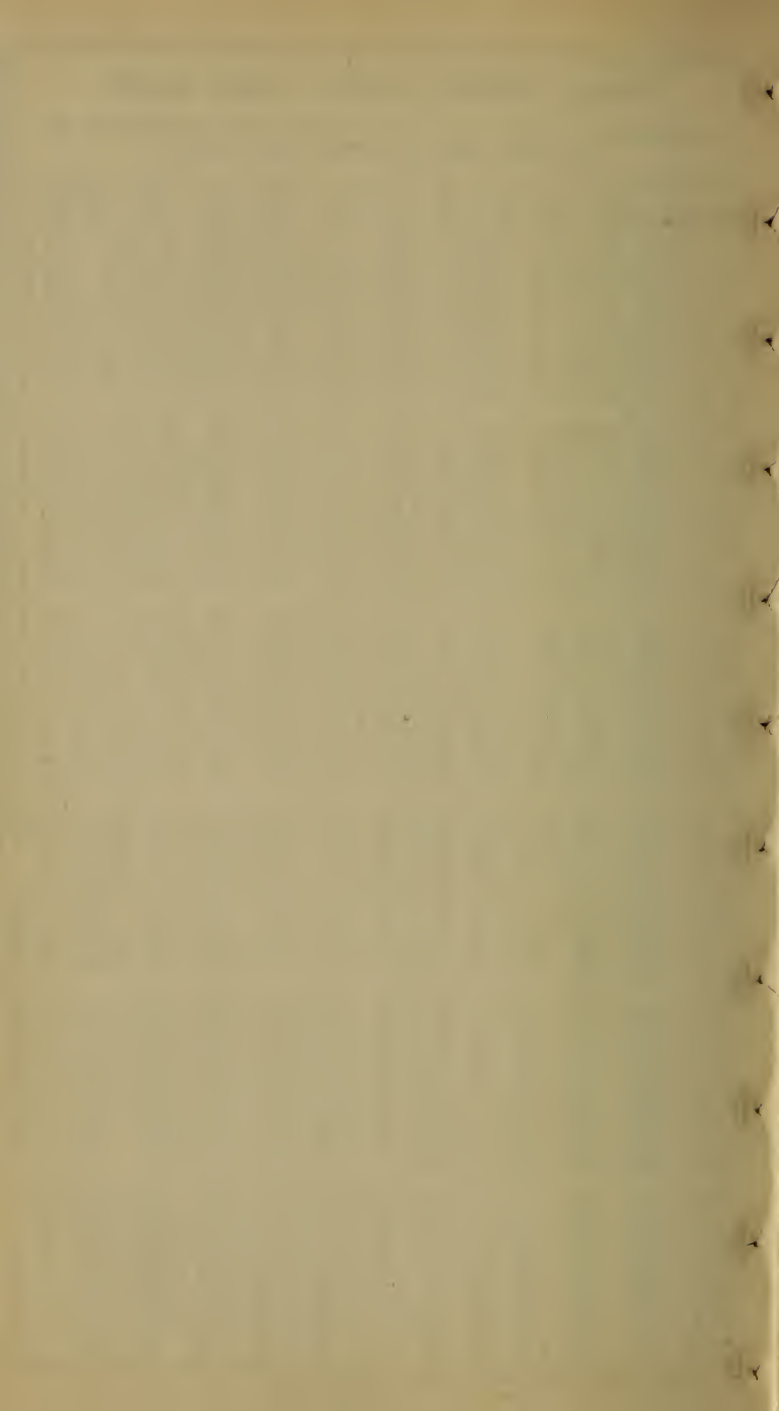
Hours to do One Piece	No. of Pieces in 8 Hours	AMOUNT PER DAY						
		4.40	4.50	4.60	4.70	4.80	4.90	5.00
		RATE PER 100 PIECES						
1	8	54.99	56.24	57.48	58.73	59.98	61.23	62.49
2	4	109.98	112.48	114.96	117.46	119.96	122.46	124.98
3	2 ^{2/3}	164.97	168.72	172.44	176.19	179.94	183.69	187.47
4	2	219.96	224.96	229.92	234.92	239.92	244.92	249.96
5	1 ^{3/4}	274.95	281.20	287.40	293.65	299.90	306.15	312.45
6	1 ^{1/3}	329.94	337.44	344.88	352.38	359.88	367.38	374.94
7	1 ^{1/4}	384.93	393.68	402.36	411.11	419.86	428.61	437.43
8	1	440.00	450.00	460.00	470.00	480.00	490.00	500.00



PIECE - FINDING TABLE — NINE HOURS

SHOWING NUMBER OF PIECES WHEN TIME REQUIRED TO
DO ONE PIECE IS OVER ONE MINUTE

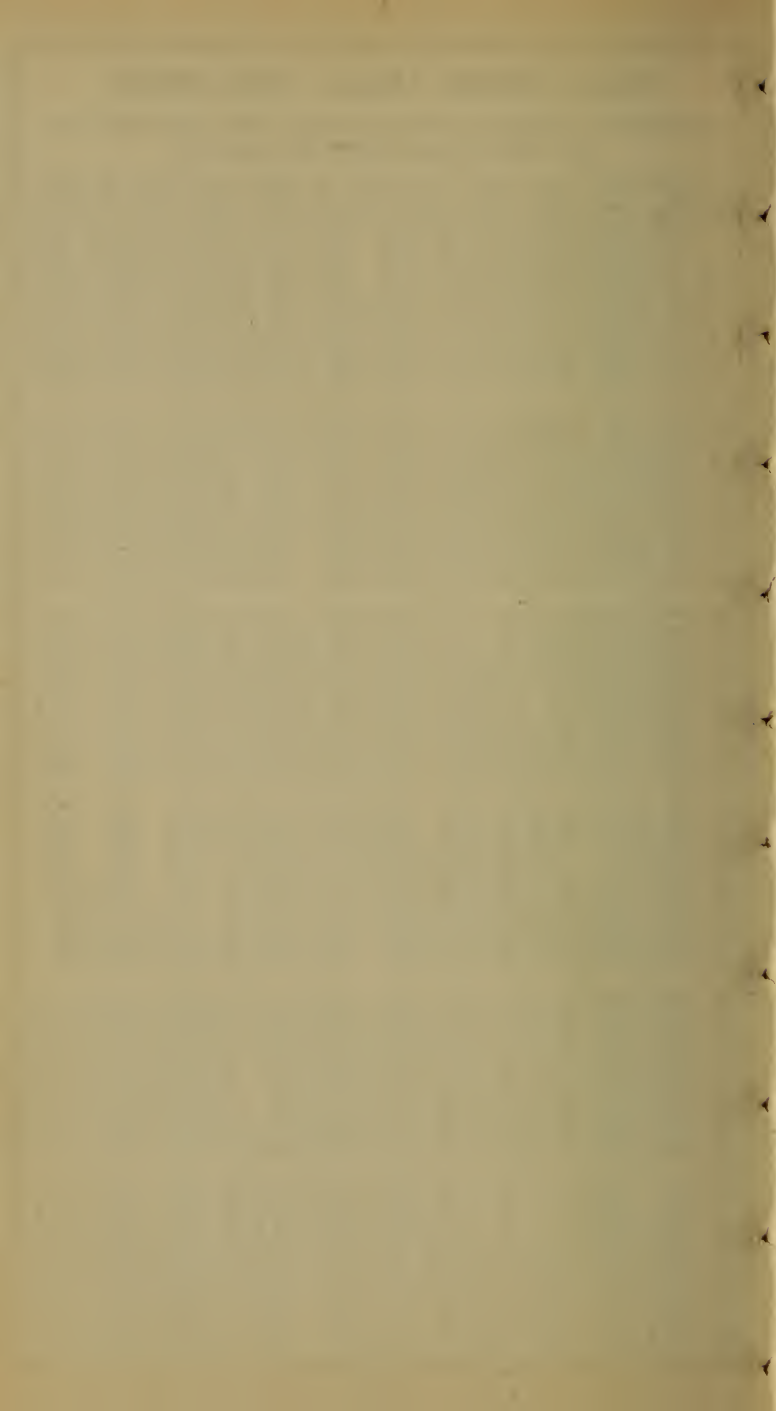
Sec.	1 Min	2 Min.	3 Min.	4 Min.	5 Min.	6 Min.	7 Min.	8. Min.	9 Min.	10 Min.	11 Min.	12 Min.
1	540	270	180	135	108	90	77	68	60	54	49.1	45
2	531	268	179	135	107.6	89.7	76.8	67.8	59.9	53.9	49.1	44.9
3	522	265	178	134	107.4	89.5	76.6	67.7	59.8	53.8	49	44.8
4	514	263	177	134	107	89.3	76.5	67.5	59.7	53.7	48.9	44.8
5	506	261	176	133	106.7	89.1	76.3	67.4	59.6	53.6	48.9	44.7
6	498	259	175	133	106.4	88.8	76.2	67.3	59.5	53.5	48.8	44.7
7	491	257	174	132	106.1	88.6	76	67.1	59.4	53.5	48.7	44.6
8	483	255	173	132	105.8	88.4	75.9	67	59.3	53.4	48.7	44.5
9	476	253	172	131	105.5	88.2	75.7	66.8	59.2	53.3	48.6	44.5
10	470	251	171	131	105.2	87.9	75.6	66.7	59.1	53.2	48.5	44.4
11	463	249	170	130	104.8	87.7	75.4	66.6	59	53.2	48.5	44.4
12	456	247	169	130	104.5	87.5	75.2	66.4	58.9	53.1	48.4	44.3
13	450	245	168	129	104.3	87.3	75.1	66.3	58.8	53	48.3	44.3
14	445	243	167	129	103.9	87	74.9	66.2	58.7	52.9	48.3	44.2
15	438	241	166	128	103.6	86.8	74.8	66	58.6	52.8	48.2	44.2
16	432	240	165	128	103.3	86.6	74.6	65.9	58.5	52.7	48.1	44.1
17	426	238	164	128	103	86.4	74.5	65.7	58.4	52.6	48.1	44
18	421	236	163	127	102.7	86.1	74.3	65.6	58.3	52.6	48	44
19	415	235	163	127	102.4	85.9	74.2	65.5	58.2	52.5	47.9	43.9
20	410	233	163	126	102.1	85.7	74	65.3	58.1	52.4	47.9	43.9
21	405	231	162	126	101.7	85.5	73.8	65.2	58	52.3	47.8	43.8
22	400	229	161	125	101.4	85.2	73.7	65.1	57.9	52.2	47.7	43.7
23	395	228	160	125	101.1	85	73.5	64.9	57.8	52.2	47.7	43.7
24	390	227	160	124	100.8	84.8	73.4	64.8	57.7	52.1	47.6	43.6
25	385	225	159	124	100.5	84.6	73.2	64.6	57.6	52	47.5	43.6
26	381	223	158	123	100.2	84.3	73.1	64.5	57.5	51.9	47.5	43.5
27	376	222	158	123	99.9	84.1	72.9	64.4	57.4	51.8	47.4	43.5
28	372	220	157	122	99.6	83.9	72.8	64.2	57.3	51.8	47.3	43.4
29	368	219	156	122	99.3	83.7	72.6	64.1	57.2	51.7	47.3	43.3
30	364	218	156	122	99	83.5	72.4	64	57.1	51.6	47.2	43.3
31	360	216	155	121	98.6	83.2	72.3	63.8	57	51.5	47.1	43.2
32	356	215	154	121	98.3	83	72.1	63.7	56.9	51.4	47.1	43.2
33	352	213	154	120	98	82.8	72	63.5	56.8	51.3	47	43.1
34	348	211	153	120	97.7	82.6	71.8	63.4	56.7	51.3	46.9	43
35	344	210	152	119	97.4	82.3	71.7	63.3	56.6	51.2	46.8	43
36	341	209	152	119	97.1	82.1	71.5	63.1	56.5	51.1	46.8	42.9
37	337	207	151	118	96.8	81.9	71.4	63	56.4	51	46.7	42.9
38	333	206	150	118	96.5	81.7	71.2	62.8	56.3	50.9	46.6	42.8
39	330	205	150	117	96.2	81.4	71.1	62.7	56.2	50.9	46.6	42.8
40	327	203	149	117	95.8	81.2	70.9	62.6	56.1	50.8	46.5	42.7
41	324	202	148	116	95.5	81	70.7	62.4	56	50.7	46.4	42.6
42	320	201	148	116	95.2	80.8	70.6	62.3	55.9	50.6	46.4	42.6
43	317	200	147	115	94.9	80.5	70.4	62.2	55.8	50.5	46.3	42.5
44	314	198	146	115	94.6	80.3	70.3	62	55.7	50.5	46.2	42.5
45	311	197	145	115	94.3	80.1	70.1	61.9	55.6	50.4	46.2	42.4
46	308	196	145	114	94	79.9	70	61.7	55.5	50.3	46.1	42.4
47	305	195	144	114	93.7	79.6	69.8	61.6	55.4	50.2	46.1	42.3
48	302	194	143	113	93.4	79.4	69.7	61.5	55.3	50.1	46	42.2
49	300	192	143	113	93.1	79.2	69.5	61.3	55.2	50	45.9	42.2
50	297	191	142	112	92.7	79	69.3	61.2	55.1	50	45.8	42.1
51	294	190	141	112	92.4	78.7	69.2	61.1	55	49.9	45.8	42.1
52	291	189	141	111	92.1	78.5	69	60.9	54.9	49.8	45.7	42
53	289	188	140	111	91.8	78.3	68.9	60.8	54.8	49.7	45.6	42
54	287	187	139	110	91.5	78.1	68.7	60.6	54.7	49.6	45.6	41.9
55	284	186	139	110	91.1	77.8	68.6	60.5	54.6	49.6	45.5	41.8
56	281	185	138	109	91	77.6	68.5	60.4	54.5	49.5	45.4	41.8
57	279	184	137	109	90.8	77.4	68.4	60.3	54.4	49.4	45.4	41.7
58	276	183	137	108	90.5	77.2	68.2	60.2	54.3	49.3	45.3	41.7
59	274	182	136	108	90.2	77.1	68.1	60.1	54.2	49.2	45.2	41.6
60	272	181	136	108	90	77	68	60	54.1	49.2	45.1	41.6



PIECE - FINDING TABLE — NINE HOURS

SHOWING NUMBER OF PIECES WHEN TIME REQUIRED TO
DO ONE PIECE IS OVER ONE MINUTE

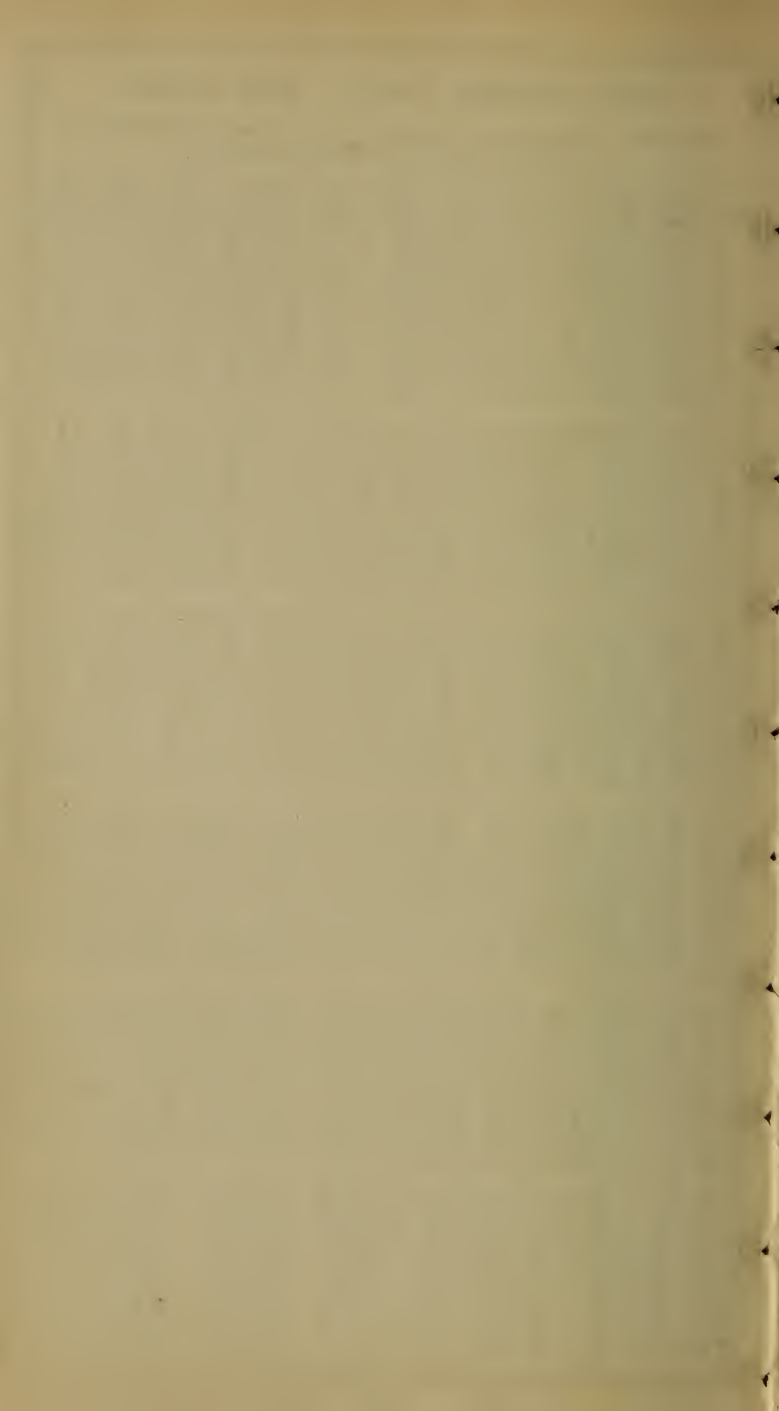
Sec.	13 Min.	14 Min.	15 Min.	16 Min.	17 Min.	18 Min.	19 Min.	20 Min.	21 Min.	22 Min.	23 Min.	24 Min.
1	41.5	38.6	36	33.7	31.8	30	28.4	27	25.7	24.5	23.5	22.5
2	41.4	38.5	35.9	33.7	31.7	30	28.4	26.9	25.7	24.5	23.5	22.5
3	41.4	38.4	35.9	33.6	31.7	30	28.4	26.9	25.7	24.5	23.5	22.5
4	41.3	38.3	35.8	33.6	31.7	30	28.4	26.9	25.6	24.5	23.5	22.5
5	41.3	38.3	35.8	33.6	31.7	29.9	28.3	26.9	25.6	24.5	23.5	22.5
6	41.2	38.2	35.8	33.5	31.6	29.9	28.3	26.9	25.6	24.4	23.4	22.5
7	41.2	38.2	35.7	33.5	31.6	29.9	28.3	26.8	25.6	24.4	23.4	22.5
8	41.1	38.1	35.7	33.5	31.6	29.9	28.3	26.8	25.6	24.4	23.4	22.4
9	41.1	38.1	35.6	33.4	31.6	29.8	28.2	26.8	25.5	24.4	23.4	22.4
	41	38.1	35.6	33.4	31.5	29.8	28.2	26.8	25.5	24.4	23.4	22.4
10	41	38	35.6	33.4	31.5	29.8	28.2	26.8	25.5	24.4	23.4	22.4
11	40.9	38	35.5	33.3	31.5	29.7	28.2	26.7	25.5	24.4	23.3	22.4
12	40.9	37.9	35.5	33.3	31.5	29.7	28.2	26.7	25.5	24.3	23.3	22.4
13	40.8	37.9	35.5	33.3	31.4	29.7	28.1	26.7	25.4	24.3	23.3	22.4
14	40.8	37.8	35.4	33.2	31.4	29.6	28.1	26.7	25.4	24.3	23.3	22.3
15	40.7	37.8	35.4	33.2	31.4	29.6	28.1	26.7	25.4	24.3	23.3	22.3
16	40.7	37.8	35.3	33.2	31.4	29.6	28.1	26.6	25.4	24.3	23.3	22.3
17	40.6	37.7	35.3	33.1	31.3	29.6	28	26.6	25.4	24.3	23.2	22.3
18	40.6	37.7	35.3	33.1	31.3	29.5	28	26.6	25.3	24.2	23.2	22.3
19	40.5	37.6	35.2	33.1	31.3	29.5	28	26.6	25.3	24.2	23.2	22.3
20	40.5	37.6	35.2	33	31.3	29.5	28	26.6	25.3	24.2	23.2	22.3
21	40.4	37.5	35.2	33	31.2	29.5	27.9	26.5	25.3	24.2	23.2	22.2
22	40.4	37.5	35.1	33	31.2	29.4	27.9	26.5	25.3	24.2	23.2	22.2
23	40.3	37.5	35.1	32.9	31.2	29.4	27.9	26.5	25.2	24.2	23.1	22.2
24	40.3	37.4	35	32.9	31.2	29.4	27.9	26.5	25.2	24.1	23.1	22.2
25	40.2	37.4	35	32.9	31.1	29.4	27.8	26.5	25.2	24.1	23.1	22.2
26	40.2	37.3	35	32.8	31.1	29.3	27.8	26.4	25.2	24.1	23.1	22.2
27	40.1	37.3	34.9	32.8	31.1	29.3	27.8	26.4	25.2	24.1	23.1	22.2
28	40.1	37.2	34.9	32.8	31.1	29.3	27.8	26.4	25.1	24.1	23.1	22.1
29	40	37.2	34.9	32.8	31	29.3	27.7	26.4	25.1	24.1	23	22.1
30	40	37.2	34.8	32.7	31	29.2	27.7	26.4	25.1	24	23	22.1
31	39.9	37.1	34.8	32.7	31	29.2	27.7	26.3	25.1	24	23	22.1
32	39.9	37.1	34.8	32.7	31	29.2	27.7	26.3	25.1	24	23	22.1
33	39.8	37	34.7	32.6	30.9	29.2	27.6	26.3	25	24	23	22.1
34	39.8	37	34.7	32.6	30.9	29.1	27.6	26.3	25	24	23	22
35	39.7	36.9	34.6	32.6	30.9	29.1	27.6	26.3	25	24	22.9	22
36	39.7	36.9	34.6	32.5	30.8	29.1	27.6	26.2	25	23.9	22.9	22
37	39.6	36.9	34.6	32.5	30.8	29.1	27.5	26.2	25	23.9	22.9	22
38	39.6	36.8	34.5	32.5	30.8	29	27.5	26.2	24.9	23.9	22.9	22
39	39.5	36.8	34.5	32.4	30.7	29	27.5	26.2	24.9	23.9	22.9	22
40	39.5	36.7	34.5	32.4	30.7	29	27.5	26.2	24.9	23.9	22.9	21.9
41	39.4	36.7	34.4	32.4	30.7	28.9	27.4	26.1	24.9	23.9	22.8	21.9
42	39.4	36.6	34.4	32.3	30.6	28.9	27.4	26.1	24.9	23.8	22.8	21.9
43	39.3	36.6	34.3	32.3	30.6	28.9	27.4	26.1	24.8	23.8	22.8	21.9
44	39.3	36.6	34.3	32.3	30.6	28.9	27.4	26	24.8	23.8	22.8	21.9
45	39.2	36.5	34.3	32.2	30.5	28.8	27.3	26	24.8	23.8	22.8	21.9
46	39.2	36.5	34.2	32.2	30.5	28.8	27.3	26	24.8	23.8	22.8	21.8
47	39.1	36.4	34.2	32.2	30.5	28.8	27.3	26	24.8	23.8	22.7	21.8
48	39.1	36.4	34.2	32.1	30.4	28.8	27.3	25.9	24.7	23.7	22.7	21.8
49	39.1	36.3	34.1	32.1	30.4	28.7	27.2	25.9	24.7	23.7	22.7	21.8
50	39	36.3	34.1	32.1	30.4	28.7	27.2	25.9	24.7	23.7	22.7	21.8
51	39	36.3	34	32	30.3	28.7	27.2	25.9	24.7	23.7	22.7	21.8
52	38.9	36.2	34	32	30.3	28.7	27.2	25.9	24.7	23.7	22.7	21.8
53	38.9	36.2	34	32	30.3	28.6	27.1	25.8	24.6	23.6	22.6	21.7
54	38.8	36.1	33.9	31.9	30.2	28.6	27.1	25.8	24.6	23.6	22.6	21.7
55	38.8	36.1	33.9	31.9	30.2	28.6	27.1	25.8	24.6	23.6	22.6	21.7
56	38.7	36	33.9	31.9	30.2	28.5	27.1	25.8	24.6	23.6	22.6	21.7
57	38.7	36	33.8	31.8	30.1	28.5	27	25.7	24.6	23.6	22.6	21.7
58	38.6	36	33.8	31.8	30.1	28.5	27	25.7	24.5	23.6	22.6	21.7
59	38.6	36	33.7	31.8	30.1	28.5	27	25.7	24.5	23.5	22.5	21.7



PIECE-FINDING TABLE — NINE HOURS

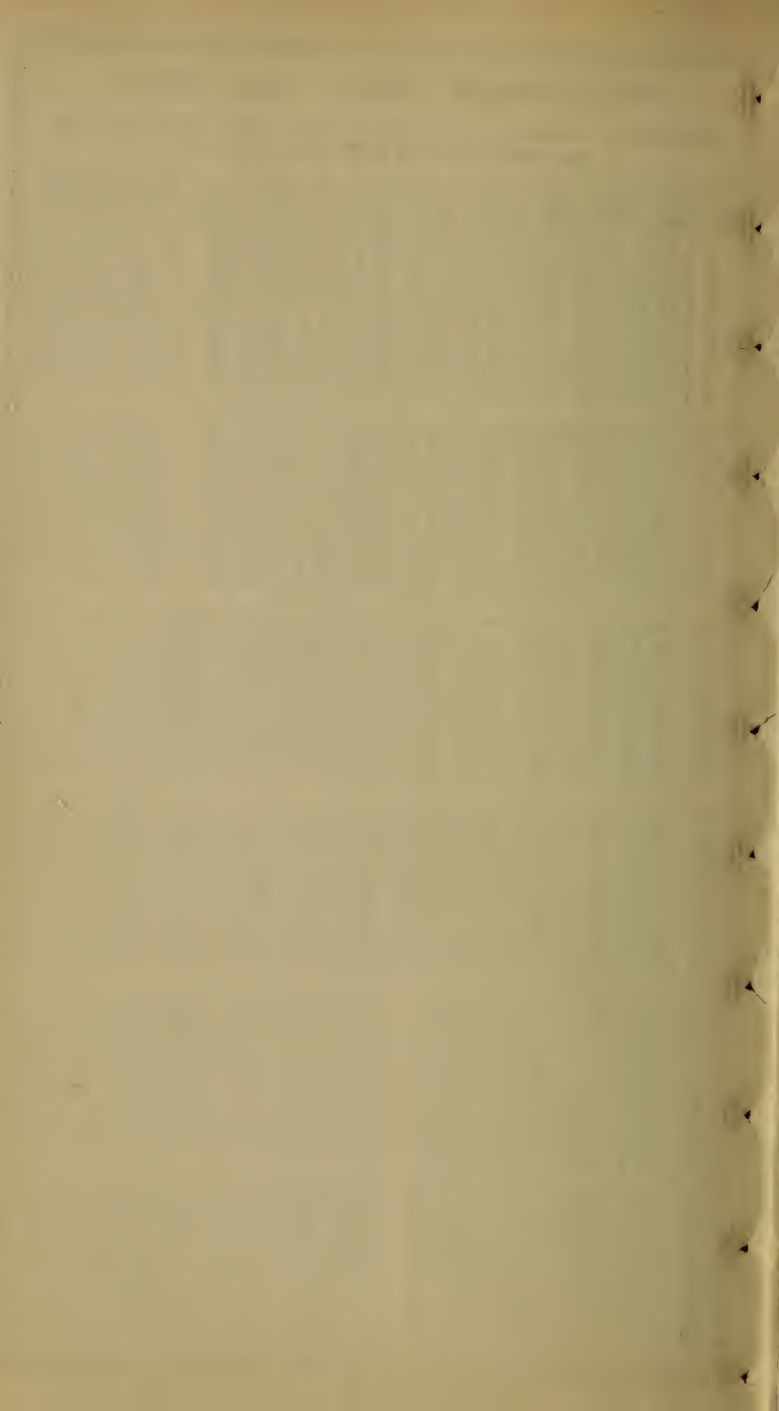
SHOWING NUMBER OF PIECES WHEN TIME REQUIRED TO
DO ONE PIECE IS OVER ONE MINUTE

Sec.	25 Min.	26 Min.	27 Min.	28 Min.	29 Min.	30 Min.	31 Min.	32 Min.	33 Min.	34 Min.	35 Min.	36 Min.
1	21.6	20.8	20	19.3	18.6	18	17.4	16.9	16.4	15.9	15.4	15
2	21.6	20.8	20	19.3	18.6	18	17.4	16.9	16.4	15.9	15.4	15
3	21.6	20.8	20	19.3	18.6	18	17.4	16.9	16.4	15.9	15.4	15
4	21.6	20.8	20	19.3	18.6	18	17.4	16.9	16.4	15.9	15.4	15
5	21.6	20.8	20	19.3	18.6	18	17.4	16.9	16.4	15.9	15.4	15
6	21.6	20.8	20	19.3	18.6	18	17.4	16.9	16.4	15.9	15.4	15
7	21.6	20.7	20	19.3	18.6	18	17.4	16.9	16.4	15.9	15.4	15
8	21.5	20.7	19.9	19.2	18.6	18	17.4	16.9	16.4	15.9	15.4	15
9	21.5	20.7	19.9	19.2	18.5	18	17.4	16.9	16.4	15.9	15.4	15
10	21.5	20.7	19.9	19.2	18.5	17.9	17.4	16.9	16.4	15.9	15.4	15
11	21.5	20.7	19.9	19.2	18.5	17.9	17.4	16.9	16.4	15.9	15.4	15
12	21.5	20.7	19.9	19.2	18.5	17.9	17.3	16.8	16.3	15.8	15.4	15
13	21.5	20.7	19.9	19.2	18.5	17.9	17.3	16.8	16.3	15.8	15.4	15
14	21.5	20.6	19.9	19.2	18.5	17.9	17.3	16.8	16.3	15.8	15.4	15
15	21.5	20.6	19.9	19.2	18.5	17.9	17.3	16.8	16.3	15.8	15.3	14.9
16	21.4	20.6	19.8	19.1	18.5	17.9	17.3	16.8	16.3	15.8	15.3	14.9
17	21.4	20.6	19.8	19.1	18.5	17.9	17.3	16.8	16.3	15.8	15.3	14.9
18	21.4	20.6	19.8	19.1	18.5	17.9	17.3	16.8	16.3	15.8	15.3	14.9
19	21.4	20.6	19.8	19.1	18.4	17.9	17.3	16.8	16.3	15.8	15.3	14.9
20	21.4	20.6	19.8	19.1	18.4	17.8	17.3	16.8	16.3	15.8	15.3	14.9
21	21.4	20.5	19.8	19.1	18.4	17.8	17.3	16.8	16.3	15.8	15.3	14.9
22	21.4	20.5	19.8	19.1	18.4	17.8	17.3	16.8	16.3	15.8	15.3	14.9
23	21.4	20.5	19.8	19.1	18.4	17.8	17.3	16.8	16.3	15.8	15.3	14.9
24	21.3	20.5	19.7	19	18.4	17.8	17.2	16.7	16.2	15.7	15.3	14.9
25	21.3	20.5	19.7	19	18.4	17.8	17.2	16.7	16.2	15.7	15.3	14.9
26	21.3	20.5	19.7	19	18.4	17.8	17.2	16.7	16.2	15.7	15.3	14.9
27	21.3	20.5	19.7	19	18.4	17.8	17.2	16.7	16.2	15.7	15.3	14.9
28	21.3	20.4	19.7	19	18.4	17.8	17.2	16.7	16.2	15.7	15.3	14.9
29	21.3	20.4	19.7	19	18.3	17.8	17.2	16.7	16.2	15.7	15.3	14.9
30	21.3	20.4	19.7	19	18.3	17.7	17.2	16.7	16.2	15.7	15.2	14.8
31	21.3	20.4	19.7	19	18.3	17.7	17.2	16.7	16.2	15.7	15.2	14.8
32	21.2	20.4	19.7	19	18.3	17.7	17.2	16.7	16.2	15.7	15.2	14.8
33	21.2	20.4	19.6	18.9	18.3	17.7	17.2	16.7	16.2	15.7	15.2	14.8
34	21.2	20.4	19.6	18.9	18.3	17.7	17.2	16.7	16.2	15.7	15.2	14.8
35	21.2	20.3	19.6	18.9	18.3	17.7	17.2	16.7	16.2	15.7	15.2	14.8
36	21.2	20.3	19.6	18.9	18.3	17.7	17.1	16.6	16.1	15.6	15.2	14.8
37	21.2	20.3	19.6	18.9	18.3	17.7	17.1	16.6	16.1	15.6	15.2	14.8
38	21.2	20.3	19.6	18.9	18.3	17.7	17.1	16.6	16.1	15.6	15.2	14.8
39	21.1	20.3	19.6	18.9	18.2	17.7	17.1	16.6	16.1	15.6	15.2	14.8
40	21.1	20.3	19.6	18.9	18.2	17.6	17.1	16.6	16.1	15.6	15.2	14.8
41	21.1	20.3	19.6	18.9	18.2	17.6	17.1	16.6	16.1	15.6	15.2	14.8
42	21.1	20.3	19.5	18.8	18.2	17.6	17.1	16.6	16.1	15.6	15.2	14.8
43	21.1	20.2	19.5	18.8	18.2	17.6	17.1	16.6	16.1	15.6	15.2	14.8
44	21.1	20.2	19.5	18.8	18.2	17.6	17.1	16.6	16.1	15.6	15.2	14.8
45	21.1	20.2	19.5	18.8	18.2	17.6	17.1	16.6	16.1	15.6	15.1	14.7
46	21	20.2	19.5	18.8	18.2	17.6	17.1	16.6	16.1	15.6	15.1	14.7
47	21	20.2	19.5	18.8	18.2	17.6	17.1	16.6	16.1	15.6	15.1	14.7
48	21	20.2	19.5	18.8	18.2	17.6	17	16.5	16	15.5	15.1	14.7
49	21	20.2	19.5	18.8	18.1	17.6	17	16.5	16	15.5	15.1	14.7
50	21	20.2	19.5	18.8	18.1	17.5	17	16.5	16	15.5	15.1	14.7
51	21	20.1	19.4	18.7	18.1	17.5	17	16.5	16	15.5	15.1	14.7
52	21	20.1	19.4	18.7	18.1	17.5	17	16.5	16	15.5	15.1	14.7
53	20.9	20.1	19.4	18.7	18.1	17.5	17	16.5	16	15.5	15.1	14.7
54	20.9	20.1	19.4	18.7	18.1	17.5	17	16.5	16	15.5	15.1	14.7
55	20.9	20.1	19.4	18.7	18.1	17.5	17	16.5	16	15.5	15.1	14.7
56	20.9	20.1	19.4	18.7	18.1	17.5	17	16.5	16	15.5	15.1	14.7
57	20.9	20.1	19.4	18.7	18.1	17.5	17	16.5	16	15.5	15.1	14.7
58	20.9	20.1	19.4	18.7	18.1	17.5	17	16.5	16	15.5	15.1	14.7
59	20.8	20.1	19.4	18.7	18.1	17.5	17	16.5	16	15.5	15.1	14.7



SHOWING NUMBER OF PIECES WHEN TIME REQUIRED TO
DO ONE PIECE IS OVER ONE MINUTE

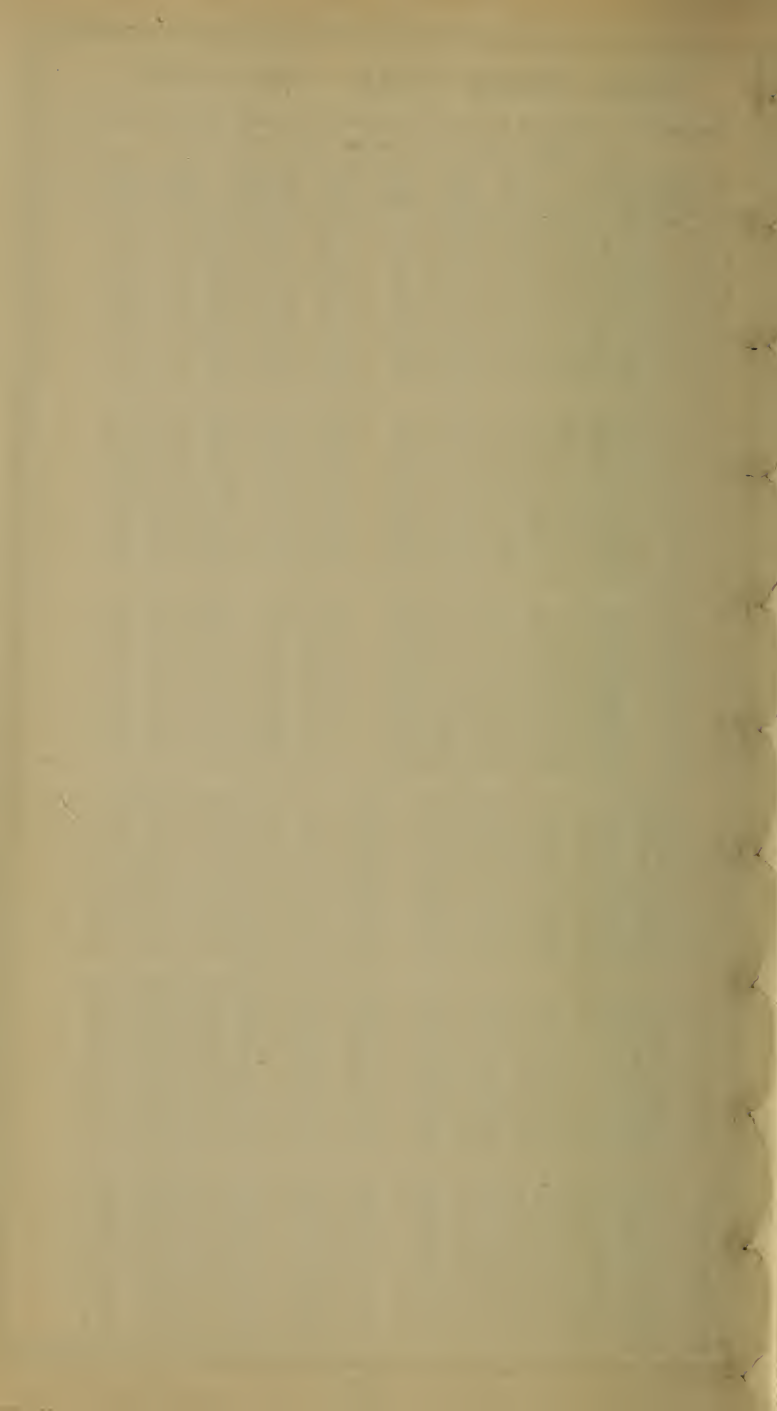
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PIECE-FINDING TABLE — NINE HOURS

SHOWING NUMBER OF PIECES WHEN TIME REQUIRED TO
DO ONE PIECE IS OVER ONE MINUTE

Sec.	49 Min.	50 Min.	51 Min.	52 Min.	53 Min.	54 Min.	55 Min.	56 Min.	57 Min.	58 Min.	59 Min.
1	11	10.8	10.6	10.4	10.2	10	9.8	9.6	9.5	9.3	9.2
2	11	10.8	10.6	10.4	10.2	10	9.8	9.6	9.5	9.3	9.2
3	11	10.8	10.6	10.4	10.2	10	9.8	9.6	9.5	9.3	9.2
4	11	10.8	10.6	10.4	10.2	10	9.8	9.6	9.5	9.3	9.2
5	11	10.8	10.6	10.4	10.2	10	9.8	9.6	9.5	9.3	9.2
6	11	10.8	10.6	10.4	10.2	10	9.8	9.6	9.5	9.3	9.2
7	11	10.8	10.6	10.4	10.2	10	9.8	9.6	9.5	9.3	9.2
8	11	10.8	10.6	10.4	10.2	10	9.8	9.6	9.5	9.3	9.2
9	11	10.8	10.6	10.4	10.2	10	9.8	9.6	9.5	9.3	9.2
10	11	10.8	10.6	10.4	10.2	10	9.8	9.6	9.5	9.3	9.2
11	11	10.8	10.6	10.4	10.2	10	9.8	9.6	9.5	9.3	9.2
12	11	10.8	10.6	10.4	10.2	10	9.8	9.6	9.5	9.3	9.2
13	11	10.8	10.6	10.4	10.2	10	9.8	9.6	9.5	9.3	9.2
14	11	10.8	10.6	10.4	10.2	10	9.8	9.6	9.5	9.3	9.2
15	11	10.8	10.6	10.4	10.2	10	9.8	9.6	9.5	9.3	9.2
16	11	10.8	10.6	10.4	10.2	10	9.8	9.6	9.5	9.3	9.2
17	11	10.8	10.6	10.4	10.2	10	9.8	9.6	9.5	9.3	9.2
18	11	10.8	10.6	10.4	10.2	10	9.8	9.6	9.5	9.3	9.2
19	11	10.8	10.6	10.4	10.2	10	9.8	9.6	9.5	9.3	9.2
20	11	10.8	10.6	10.4	10.2	10	9.8	9.6	9.5	9.3	9.2
21	11	10.8	10.6	10.4	10.2	10	9.8	9.6	9.5	9.3	9.2
22	11	10.8	10.6	10.4	10.2	10	9.8	9.6	9.5	9.3	9.2
23	11	10.8	10.6	10.4	10.2	10	9.8	9.6	9.5	9.3	9.2
24	11	10.8	10.6	10.4	10.2	10	9.8	9.6	9.5	9.3	9.2
25	11	10.8	10.6	10.4	10.2	10	9.8	9.6	9.5	9.3	9.2
26	11	10.8	10.6	10.4	10.2	10	9.8	9.6	9.5	9.3	9.2
27	11	10.8	10.6	10.4	10.2	10	9.8	9.6	9.5	9.3	9.2
28	11	10.8	10.6	10.4	10.2	10	9.8	9.6	9.5	9.3	9.2
29	11	10.8	10.6	10.4	10.2	10	9.8	9.6	9.5	9.3	9.2
30	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1
31	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1
32	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1
33	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1
34	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1
35	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1
36	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1
37	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1
38	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1
39	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1
40	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1
41	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1
42	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1
43	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1
44	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1
45	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1
46	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1
47	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1
48	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1
49	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1
50	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1
51	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1
52	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1
53	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1
54	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1
55	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1
56	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1
57	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1
58	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1
59	10.9	10.7	10.5	10.3	10.1	9.9	9.7	9.6	9.4	9.2	9.1



PIECE WORK RATE-SETTING TABLE

NINE HOURS A DAY

Sec. to do One Piece	No. of Pieces in One Hour	No. of Pieces in Nine Hours	AMOUNT PER DAY								
			.75	.80	.90	1.00	1.10	1.20	1.25	1.30	1.40
			RATE PER 100 PIECES								
1	3600	32400	.0023	.0025	.0028	.0031	.0034	.0037	.0039	.0040	.0043
2	1800	16200	.0046	.0049	.0056	.0062	.0068	.0074	.0077	.0080	.0086
3	1200	10800	.0069	.0074	.0083	.0093	.0102	.0111	.0116	.0120	.0130
4	900	8100	.0093	.0099	.0111	.0123	.0136	.0148	.0154	.0160	.0173
5	720	6480	.0116	.0123	.0139	.0154	.0170	.0185	.0193	.0201	.0216
6	600	5400	.0139	.0148	.0167	.0185	.0204	.0222	.0231	.0241	.0259
7	514	4628	.0162	.0173	.0194	.0216	.0238	.0259	.0270	.0281	.0302
8	450	4050	.0185	.0198	.0222	.0247	.0272	.0296	.0309	.0321	.0346
9	400	3600	.0208	.0222	.0250	.0278	.0306	.0333	.0347	.0361	.0389
10	360	3240	.0231	.0247	.0278	.0309	.0340	.0370	.0386	.0401	.0432
11	327	2945	.0255	.0272	.0305	.0339	.0373	.0407	.0424	.0441	.0475
12	300	2700	.0278	.0296	.0333	.0370	.0407	.0444	.0463	.0481	.0518
13	277	2492	.0301	.0321	.0361	.0401	.0441	.0481	.0502	.0522	.0561
14	257	2314	.0324	.0346	.0389	.0432	.0475	.0518	.0540	.0562	.0605
15	240	2160	.0347	.0370	.0417	.0463	.0509	.0555	.0579	.0602	.0648
16	225	2025	.0370	.0395	.0444	.0494	.0543	.0593	.0617	.0642	.0691
17	212	1906	.0393	.0420	.0472	.0525	.0577	.0630	.0656	.0682	.0735
18	200	1800	.0417	.0444	.0500	.0555	.0611	.0667	.0694	.0722	.0778
19	190	1705	.0440	.0469	.0528	.0586	.0645	.0704	.0733	.0762	.0821
20	180	1620	.0463	.0494	.0555	.0617	.0679	.0741	.0772	.0802	.0864
21	171	1543	.0486	.0518	.0583	.0648	.0713	.0778	.0810	.0843	.0907
22	164	1473	.0509	.0543	.0611	.0679	.0747	.0815	.0849	.0883	.0951
23	157	1409	.0532	.0568	.0639	.0710	.0781	.0852	.0887	.0923	.0994
24	150	1350	.0555	.0593	.0666	.0741	.0815	.0889	.0926	.0963	.1037
25	144	1296	.0578	.0617	.0694	.0772	.0849	.0926	.0965	.1003	.1080
26	138	1246	.0602	.0642	.0722	.0802	.0883	.0963	.1003	.1043	.1123
27	133	1200	.0624	.0667	.0750	.0833	.0917	.1000	.1042	.1083	.1167
28	129	1157	.0648	.0691	.0778	.0864	.0951	.1037	.1080	.1123	.1210
29	124	1117	.0671	.0716	.0805	.0895	.0985	.1074	.1119	.1163	.1253
30	120	1080	.0694	.0741	.0833	.0926	.1019	.1111	.1157	.1204	.1296
31	116	1045	.0717	.0765	.0861	.0957	.1053	.1148	.1196	.1244	.1340
32	112	1012	.0740	.0790	.0889	.0988	.1086	.1185	.1235	.1284	.1383
33	109	982	.0764	.0815	.0916	.1018	.1120	.1222	.1273	.1324	.1426
34	106	953	.0787	.0839	.0944	.1049	.1154	.1259	.1312	.1364	.1469
35	103	926	.0810	.0864	.0972	.1080	.1188	.1296	.1350	.1404	.1512
36	100	900	.0833	.0889	.1000	.1111	.1222	.1333	.1389	.1444	.1556
37	97	876	.0856	.0914	.1027	.1142	.1256	.1370	.1427	.1484	.1599
38	95	852	.0879	.0938	.1055	.1173	.1290	.1407	.1466	.1525	.1642
39	92	831	.0902	.0963	.1083	.1204	.1324	.1444	.1505	.1565	.1685
40	90	810	.0926	.0988	.1111	.1234	.1358	.1481	.1543	.1605	.1728
41	88	790	.0949	.1012	.1139	.1265	.1392	.1518	.1582	.1645	.1772
42	86	771	.0972	.1037	.1166	.1296	.1426	.1555	.1620	.1685	.1815
43	84	753	.0995	.1062	.1194	.1327	.1460	.1592	.1659	.1725	.1858
44	82	736	.1018	.1086	.1222	.1358	.1494	.1629	.1698	.1765	.1901
45	80	720	.1041	.1111	.1250	.1389	.1528	.1666	.1736	.1805	.1944
46	78	704	.1064	.1136	.1277	.1420	.1562	.1703	.1775	.1846	.1988
47	76	689	.1088	.1160	.1305	.1450	.1596	.1740	.1813	.1886	.2031
48	75	675	.1111	.1185	.1333	.1481	.1630	.1777	.1852	.1926	.2074
49	73	661	.1134	.1220	.1361	.1512	.1664	.1815	.1890	.1966	.2117
50	72	648	.1157	.1235	.1389	.1543	.1698	.1852	.1929	.2006	.2160
51	71	635	.1180	.1259	.1416	.1574	.1732	.1889	.1968	.2046	.2204
52	69	623	.1203	.1284	.1444	.1605	.1765	.1926	.2006	.2086	.2247
53	68	611	.1226	.1309	.1472	.1636	.1799	.1963	.2045	.2126	.2290
54	67	600	.1250	.1333	.1500	.1666	.1833	.2000	.2083	.2166	.2333
55	65	589	.1273	.1358	.1527	.1697	.1867	.2037	.2122	.2207	.2377
56	64	578	.1296	.1383	.1555	.1728	.1901	.2074	.2160	.2247	.2420
57	63	568	.1319	.1407	.1583	.1759	.1935	.2111	.2199	.2287	.2463
58	62	558	.1342	.1432	.1611	.1790	.1969	.2148	.2238	.2327	.2506
59	61	549	.1365	.1457	.1638	.1821	.2003	.2185	.2276	.2367	.2549
60	60	540	.1388	.1481	.1666	.1852	.2037	.2222	.2315	.2407	.2593

PIECE WORK RATE-SETTING TABLE

NINE HOURS A DAY

Sec. to do One Piece	No. of Pieces in One Hour	No. of Pieces in Nine Hours	AMOUNT PER DAY								
			1.50	1.60	1.70	1.75	1.80	1.90	2.00	2.10	2.25
			RATE PER 100 PIECES								
1	3600	32400	.0046	.0049	.0053	.0054	.0056	.0059	.0062	.0065	.0069
2	1800	16200	.0093	.0099	.0105	.0108	.0111	.0117	.0123	.0130	.0139
3	1200	10800	.0139	.0148	.0157	.0162	.0167	.0176	.0185	.0194	.0208
4	900	8100	.0185	.0198	.0210	.0216	.0222	.0235	.0247	.0259	.0278
5	720	6480	.0231	.0247	.0262	.0270	.0278	.0293	.0309	.0324	.0347
6	600	5400	.0278	.0296	.0315	.0324	.0333	.0352	.0370	.0389	.0417
7	514	4628	.0324	.0346	.0367	.0378	.0389	.0410	.0432	.0454	.0486
8	450	4050	.0370	.0395	.0420	.0432	.0444	.0469	.0494	.0518	.0556
9	400	3600	.0417	.0444	.0472	.0486	.0500	.0528	.0556	.0583	.0625
10	360	3240	.0463	.0494	.0525	.0540	.0556	.0586	.0617	.0648	.0694
11	327	2945	.0509	.0543	.0577	.0594	.0611	.0645	.0679	.0713	.0764
12	300	2700	.0555	.0593	.0630	.0648	.0667	.0704	.0741	.0778	.0833
13	277	2492	.0602	.0642	.0682	.0702	.0722	.0762	.0802	.0843	.0903
14	257	2314	.0648	.0691	.0735	.0756	.0778	.0821	.0864	.0907	.0972
15	240	2160	.0694	.0741	.0787	.0810	.0833	.0880	.0926	.0972	.1042
16	225	2025	.0741	.0790	.0840	.0864	.0889	.0938	.0988	.1037	.1111
17	212	1906	.0787	.0839	.0892	.0918	.0944	.0997	.1049	.1102	.1180
18	200	1800	.0833	.0889	.0944	.0972	.1000	.1056	.1111	.1167	.1250
19	190	1705	.0880	.0938	.0977	.1026	.1055	.1114	.1173	.1231	.1319
20	180	1620	.0926	.0988	.1049	.1080	.1111	.1173	.1235	.1296	.1389
21	171	1543	.0972	.1037	.1102	.1134	.1167	.1231	.1296	.1361	.1458
22	164	1473	.1018	.1086	.1154	.1188	.1222	.1290	.1358	.1426	.1528
23	157	1409	.1065	.1136	.1207	.1242	.1278	.1349	.1420	.1491	.1597
24	150	1350	.1111	.1185	.1259	.1296	.1333	.1407	.1482	.1555	.1667
25	144	1296	.1157	.1235	.1312	.1350	.1389	.1466	.1543	.1620	.1736
26	138	1246	.1204	.1284	.1364	.1404	.1444	.1525	.1605	.1685	.1805
27	133	1200	.1250	.1333	.1417	.1458	.1500	.1583	.1667	.1750	.1875
28	129	1157	.1296	.1383	.1469	.1512	.1555	.1642	.1728	.1815	.1944
29	124	1117	.1342	.1432	.1522	.1566	.1611	.1701	.1790	.1879	.2014
30	120	1080	.1389	.1481	.1574	.1620	.1667	.1759	.1852	.1944	.2083
31	116	1045	.1435	.1531	.1627	.1674	.1722	.1818	.1914	.2009	.2153
32	112	1012	.1481	.1580	.1679	.1728	.1778	.1876	.1975	.2074	.2222
33	109	982	.1528	.1630	.1732	.1782	.1833	.1935	.2037	.2139	.2292
34	106	953	.1574	.1679	.1784	.1836	.1889	.1994	.2099	.2204	.2361
35	103	926	.1620	.1728	.1836	.1890	.1944	.2052	.2161	.2268	.2430
36	100	900	.1666	.1778	.1889	.1944	.2000	.2111	.2222	.2333	.2500
37	97	876	.1713	.1827	.1941	.1998	.2055	.2170	.2284	.2398	.2569
38	95	852	.1759	.1876	.1994	.2052	.2111	.2228	.2346	.2463	.2639
39	92	831	.1805	.1926	.2046	.2106	.2166	.2287	.2407	.2528	.2708
40	90	810	.1852	.1975	.2099	.2160	.2222	.2346	.2469	.2592	.2778
41	88	790	.1898	.2025	.2151	.2214	.2278	.2404	.2531	.2657	.2847
42	86	771	.1944	.2074	.2204	.2268	.2333	.2463	.2593	.2722	.2916
43	84	753	.1990	.2123	.2256	.2322	.2389	.2522	.2654	.2787	.2986
44	82	736	.2037	.2173	.2309	.2376	.2444	.2580	.2716	.2852	.3055
45	80	720	.2083	.2222	.2361	.2430	.2500	.2639	.2778	.2916	.3125
46	78	704	.2129	.2271	.2414	.2484	.2555	.2697	.2840	.2981	.3194
47	76	689	.2176	.2321	.2466	.2538	.2611	.2756	.2901	.3046	.3264
48	75	675	.2222	.2370	.2519	.2592	.2666	.2815	.2963	.3111	.3333
49	73	661	.2268	.2420	.2571	.2646	.2722	.2873	.3025	.3176	.3403
50	72	648	.2315	.2469	.2624	.2701	.2778	.2932	.3087	.3241	.3472
51	71	635	.2361	.2518	.2676	.2755	.2833	.2991	.3148	.3305	.3541
52	69	623	.2407	.2568	.2728	.2809	.2889	.3049	.3210	.3370	.3611
53	68	611	.2453	.2617	.2781	.2863	.2944	.3108	.3272	.3435	.3680
54	67	600	.2500	.2667	.2833	.2917	.3000	.3167	.3333	.3500	.3750
55	65	589	.2546	.2716	.2886	.2971	.3055	.3225	.3395	.3565	.3819
56	64	578	.2592	.2765	.2938	.3025	.3111	.3284	.3457	.3629	.3889
57	63	568	.2639	.2815	.2991	.3079	.3166	.3342	.3519	.3694	.3958
58	62	558	.2685	.2864	.3043	.3133	.3222	.3401	.3580	.3759	.4028
59	61	549	.2731	.2913	.3096	.3187	.3277	.3460	.3642	.3824	.4097
60	60	540	.2777	.2963	.3148	.3241	.3333	.3518	.3704	.3889	.4166

PIECE WORK RATE-SETTING TABLE

NINE HOURS A DAY

Sec. to do One Piece	No. of Pieces in One Hour	No. of Pieces in Nine Hours	AMOUNT PER DAY								
			2.40	2.50	2.60	2.75	2.80	2.90	3.00	3.10	3.20
			RATE PER 100 PIECES								
1	3600	32400	.0074	.0077	.0080	.0085	.0086	.0090	.0093	.0096	.0099
2	1800	16200	.0148	.0154	.0161	.0170	.0173	.0179	.0185	.0191	.0198
3	1200	10800	.0222	.0231	.0241	.0255	.0259	.0269	.0278	.0287	.0296
4	900	8100	.0296	.0309	.0321	.0339	.0346	.0358	.0370	.0383	.0395
5	720	6480	.0370	.0386	.0401	.0424	.0432	.0448	.0463	.0478	.0494
6	600	5400	.0444	.0463	.0482	.0509	.0519	.0537	.0556	.0574	.0593
7	514	4628	.0518	.0540	.0562	.0594	.0605	.0627	.0648	.0670	.0691
8	450	4050	.0593	.0617	.0642	.0679	.0691	.0716	.0741	.0765	.0790
9	400	3600	.0667	.0694	.0722	.0764	.0778	.0806	.0833	.0861	.0889
10	360	3240	.0741	.0772	.0803	.0849	.0864	.0895	.0926	.0957	.0988
11	327	2945	.0815	.0849	.0883	.0934	.0951	.0985	.1018	.1052	.1086
12	300	2700	.0889	.0926	.0963	.1018	.1037	.1074	.1111	.1148	.1185
13	277	2492	.0963	.1003	.1043	.1103	.1123	.1164	.1204	.1244	.1284
14	257	2314	.1037	.1080	.1124	.1188	.1210	.1253	.1296	.1339	.1383
15	240	2160	.1111	.1157	.1204	.1273	.1296	.1343	.1389	.1435	.1482
16	225	2025	.1185	.1235	.1284	.1358	.1383	.1432	.1481	.1531	.1580
17	212	1906	.1259	.1312	.1364	.1443	.1469	.1522	.1574	.1626	.1679
18	200	1800	.1333	.1389	.1445	.1528	.1556	.1611	.1667	.1722	.1778
19	190	1705	.1407	.1466	.1525	.1613	.1642	.1701	.1759	.1818	.1877
20	180	1620	.1481	.1543	.1605	.1697	.1728	.1790	.1852	.1913	.1975
21	171	1543	.1555	.1620	.1685	.1782	.1815	.1880	.1944	.2009	.2074
22	164	1473	.1630	.1698	.1766	.1867	.1901	.1969	.2037	.2105	.2173
23	157	1409	.1704	.1775	.1846	.1952	.1988	.2059	.2130	.2200	.2272
24	150	1350	.1778	.1852	.1926	.2037	.2074	.2148	.2222	.2296	.2370
25	144	1296	.1852	.1929	.2006	.2122	.2161	.2238	.2315	.2393	.2469
26	138	1246	.1926	.2006	.2087	.2207	.2247	.2327	.2407	.2487	.2568
27	133	1200	.2000	.2083	.2167	.2291	.2333	.2417	.2500	.2583	.2667
28	129	1157	.2075	.2160	.2247	.2376	.2420	.2506	.2593	.2679	.2766
29	124	1117	.2148	.2238	.2327	.2461	.2506	.2596	.2685	.2774	.2864
30	120	1080	.2222	.2315	.2408	.2546	.2593	.2685	.2778	.2870	.2963
31	116	1045	.2296	.2392	.2488	.2631	.2679	.2775	.2870	.2966	.3062
32	112	1012	.2370	.2469	.2568	.2716	.2765	.2865	.2963	.3061	.3161
33	109	982	.2444	.2546	.2648	.2801	.2852	.2954	.3055	.3157	.3259
34	106	953	.2518	.2623	.2729	.2886	.2938	.3043	.3148	.3253	.3358
35	103	926	.2592	.2701	.2809	.2970	.3025	.3133	.3241	.3348	.3457
36	100	900	.2667	.2778	.2889	.3055	.3111	.3222	.3333	.3444	.3556
37	97	876	.2741	.2855	.2969	.3140	.3198	.3312	.3426	.3540	.3654
38	95	852	.2815	.2932	.3050	.3225	.3284	.3401	.3518	.3635	.3753
39	92	831	.2889	.3009	.3130	.3310	.3370	.3491	.3611	.3731	.3852
40	90	810	.2963	.3086	.3210	.3395	.3457	.3580	.3704	.3827	.3951
41	88	790	.3037	.3164	.3290	.3480	.3543	.3670	.3796	.3922	.4050
42	86	771	.3111	.3241	.3371	.3565	.3630	.3759	.3889	.4018	.4148
43	84	753	.3185	.3318	.3451	.3649	.3716	.3849	.3981	.4114	.4247
44	82	736	.3259	.3395	.3531	.3734	.3802	.3938	.4074	.4209	.4346
45	80	720	.3333	.3472	.3611	.3819	.3889	.4028	.4167	.4305	.4445
46	78	704	.3407	.3549	.3691	.3904	.3975	.4117	.4259	.4401	.4543
47	76	689	.3481	.3627	.3772	.3989	.4062	.4207	.4352	.4496	.4642
48	75	675	.3555	.3704	.3852	.4074	.4148	.4296	.4444	.4592	.4741
49	73	661	.3629	.3781	.3932	.4159	.4235	.4386	.4537	.4688	.4840
50	72	648	.3704	.3858	.4013	.4244	.4321	.4476	.4630	.4784	.4939
51	71	635	.3778	.3935	.4093	.4328	.4407	.4565	.4722	.4879	.5037
52	69	623	.3852	.4012	.4173	.4413	.4494	.4655	.4815	.4975	.5136
53	68	611	.3926	.4089	.4253	.4498	.4580	.4744	.4907	.5071	.5235
54	67	600	.4000	.4167	.4334	.4583	.4667	.4834	.5000	.5166	.5334
55	65	589	.4074	.4244	.4414	.4668	.4753	.4923	.5092	.5262	.5432
56	64	578	.4148	.4321	.4494	.4753	.4840	.5013	.5185	.5358	.5531
57	63	568	.4222	.4398	.4574	.4838	.4926	.5102	.5278	.5453	.5630
58	62	558	.4296	.4475	.4655	.4922	.5012	.5192	.5370	.5549	.5729
59	61	549	.4370	.4552	.4735	.5007	.5099	.5281	.5463	.5645	.5827
60	60	540	.4444	.4630	.4815	.5092	.5185	.5371	.5555	.5740	.5926

PIECE WORK RATE-SETTING TABLE

NINE HOURS A DAY

Sec. to do One Piece	No. of Pieces in One Hour	No. of Pieces in Nine Hours	AMOUNT PER DAY								
			3.30	3.40	3.50	3.60	3.70	3.80	3.90	4.00	4.10
			RATE PER 100 PIECES								
1	3600	32400	.0102	.0105	.0108	.0111	.0114	.0117	.0120	.0123	.0127
2	1800	16200	.0204	.0210	.0216	.0222	.0228	.0235	.0241	.0247	.0253
3	1200	10800	.0306	.0315	.0324	.0333	.0343	.0352	.0361	.0370	.0380
4	900	8100	.0407	.0420	.0432	.0444	.0457	.0469	.0481	.0494	.0506
5	720	6480	.0509	.0525	.0540	.0555	.0571	.0586	.0602	.0617	.0633
6	600	5400	.0611	.0630	.0648	.0666	.0685	.0704	.0722	.0751	.0760
7	514	4628	.0713	.0735	.0756	.0777	.0799	.0821	.0842	.0864	.0886
8	450	4050	.0815	.0839	.0864	.0888	.0913	.0938	.0963	.0987	.1012
9	400	3600	.0917	.0944	.0972	.1000	.1028	.1055	.1083	.1111	.1139
10	360	3240	.1019	.1049	.1080	.1111	.1142	.1173	.1203	.1234	.1265
11	327	2945	.1120	.1154	.1188	.1222	.1256	.1290	.1324	.1358	.1392
12	300	2700	.1222	.1259	.1296	.1333	.1370	.1407	.1444	.1481	.1518
13	277	2492	.1324	.1364	.1404	.1444	.1484	.1524	.1564	.1604	.1645
14	257	2314	.1426	.1469	.1512	.1555	.1599	.1642	.1685	.1728	.1771
15	240	2160	.1528	.1574	.1620	.1667	.1713	.1759	.1805	.1851	.1898
16	225	2025	.1630	.1679	.1728	.1778	.1827	.1876	.1925	.1975	.2024
17	212	1906	.1731	.1784	.1836	.1889	.1941	.1993	.2046	.2098	.2151
18	200	1800	.1833	.1889	.1944	.2000	.2055	.2111	.2166	.2222	.2277
19	190	1705	.1935	.1994	.2052	.2111	.2169	.2228	.2286	.2345	.2404
20	180	1620	.2037	.2099	.2160	.2222	.2284	.2345	.2407	.2468	.2530
21	171	1543	.2139	.2204	.2268	.2333	.2398	.2462	.2527	.2592	.2657
22	164	1473	.2241	.2308	.2376	.2444	.2512	.2580	.2647	.2715	.2783
23	157	1409	.2343	.2413	.2484	.2555	.2626	.2697	.2768	.2839	.2910
24	150	1350	.2444	.2518	.2592	.2666	.2740	.2814	.2888	.2962	.3036
25	144	1296	.2546	.2623	.2700	.2778	.2855	.2932	.3009	.3086	.3163
26	138	1246	.2648	.2728	.2808	.2889	.2969	.3049	.3129	.3209	.3289
27	133	1200	.2750	.2833	.2916	.3000	.3083	.3166	.3249	.3332	.3416
28	129	1157	.2852	.2938	.3024	.3111	.3197	.3283	.3370	.3456	.3542
29	124	1117	.2954	.3043	.3132	.3222	.3311	.3401	.3490	.3579	.3669
30	120	1080	.3056	.3148	.3240	.3333	.3425	.3518	.3610	.3703	.3795
31	116	1045	.3157	.3253	.3348	.3444	.3540	.3635	.3731	.3826	.3922
32	112	1012	.3259	.3358	.3456	.3555	.3654	.3752	.3851	.3949	.4048
33	109	982	.3361	.3463	.3564	.3666	.3768	.3870	.3971	.4073	.4175
34	106	953	.3463	.3568	.3672	.3777	.3882	.3987	.4092	.4196	.4301
35	103	926	.3565	.3673	.3780	.3889	.3996	.4104	.4212	.4320	.4428
36	100	900	.3667	.3777	.3888	.4000	.4110	.4221	.4332	.4443	.4554
37	97	876	.3768	.3882	.3996	.4111	.4225	.4339	.4453	.4567	.4681
38	95	852	.3870	.3987	.4104	.4222	.4339	.4457	.4573	.4690	.4807
39	92	831	.3972	.4092	.4212	.4333	.4453	.4573	.4693	.4813	.4934
40	90	810	.4074	.4197	.4320	.4444	.4567	.4690	.4814	.4937	.5060
41	88	790	.4176	.4302	.4428	.4555	.4681	.4808	.4934	.5060	.5187
42	86	771	.4278	.4407	.4536	.4666	.4796	.4925	.5054	.5184	.5313
43	84	753	.4380	.4512	.4644	.4777	.4910	.5042	.5175	.5307	.5440
44	82	736	.4481	.4617	.4752	.4888	.5024	.5159	.5295	.5430	.5566
45	80	720	.4583	.4722	.4860	.5000	.5138	.5277	.5415	.5554	.5693
46	78	704	.4685	.4827	.4968	.5111	.5252	.5394	.5536	.5677	.5819
47	76	689	.4787	.4932	.5076	.5222	.5366	.5511	.5656	.5801	.5946
48	75	675	.4889	.5037	.5184	.5333	.5481	.5628	.5776	.5924	.6072
49	73	661	.4991	.5142	.5292	.5445	.5595	.5746	.5897	.6048	.6199
50	72	648	.5093	.5247	.5401	.5555	.5709	.5863	.6017	.6171	.6325
51	71	635	.5194	.5351	.5509	.5666	.5823	.5980	.6137	.6294	.6452
52	69	623	.5296	.5456	.5617	.5777	.5937	.6098	.6258	.6418	.6578
53	68	611	.5398	.5561	.5725	.5888	.6052	.6215	.6378	.6541	.6705
54	67	600	.5500	.5666	.5833	.6000	.6166	.6332	.6498	.6665	.6831
55	65	589	.5602	.5771	.5941	.6111	.6280	.6449	.6619	.6788	.6958
56	64	578	.5704	.5876	.6049	.6222	.6394	.6567	.6739	.6912	.7084
57	63	568	.5805	.5981	.6157	.6333	.6508	.6684	.6859	.7035	.7211
58	62	558	.5907	.6086	.6265	.6444	.6622	.6801	.6980	.7158	.7337
59	61	549	.6009	.6191	.6373	.6555	.6737	.6918	.7100	.7282	.7464
60	60	540	.6111	.6296	.6481	.6666	.6851	.7036	.7220	.7405	.7590

PIECE WORK RATE - SETTING TABLE

NINE HOURS A DAY

Sec. to do One Piece	No. of Pieces in One Hour	No. of Pieces in Nine Hours	AMOUNT PER DAY								
			4.20	4.30	4.40	4.50	4.60	4.70	4.80	4.90	5.00
			RATE PER 100 PIECES								
1	3600	32400	.0130	.0133	.0136	.0139	.0142	.0145	.0148	.0151	.0154
2	1800	16200	.0259	.0265	.0272	.0278	.0284	.0290	.0296	.0302	.0308
3	1200	10800	.0389	.0398	.0407	.0417	.0426	.0435	.0444	.0453	.0463
4	900	8100	.0518	.0531	.0543	.0555	.0568	.0580	.0592	.0605	.0617
5	720	6480	.0648	.0663	.0679	.0694	.0710	.0725	.0740	.0756	.0771
6	600	5400	.0777	.0796	.0815	.0833	.0852	.0870	.0888	.0907	.0925
7	514	4628	.0907	.0929	.0950	.0972	.0993	.1015	.1037	.1058	.1080
8	450	4050	.1037	.1061	.1086	.1111	.1135	.1160	.1185	.1209	.1234
9	400	3600	.1166	.1194	.1222	.1250	.1277	.1305	.1333	.1360	.1388
10	360	3240	.1296	.1327	.1358	.1388	.1419	.1450	.1481	.1512	.1542
11	327	2945	.1425	.1459	.1493	.1527	.1561	.1595	.1629	.1663	.1697
12	300	2700	.1555	.1592	.1629	.1666	.1703	.1740	.1777	.1814	.1851
13	277	2492	.1685	.1725	.1765	.1805	.1845	.1885	.1925	.1965	.2005
14	257	2314	.1814	.1857	.1901	.1944	.1987	.2030	.2073	.2116	.2159
15	240	2160	.1944	.1990	.2036	.2081	.2129	.2175	.2221	.2267	.2314
16	225	2025	.2073	.2123	.2172	.2221	.2271	.2320	.2369	.2419	.2468
17	212	1906	.2203	.2255	.2308	.2360	.2413	.2465	.2517	.2570	.2622
18	200	1800	.2332	.2388	.2444	.2499	.2555	.2610	.2665	.2721	.2776
19	190	1705	.2462	.2521	.2579	.2638	.2696	.2755	.2814	.2872	.2931
20	180	1620	.2592	.2653	.2715	.2777	.2838	.2900	.2962	.3023	.3085
21	171	1543	.2721	.2786	.2851	.2916	.2980	.3045	.3110	.3174	.3239
22	164	1473	.2851	.2919	.2987	.3054	.3122	.3190	.3258	.3326	.3393
23	157	1409	.2980	.3051	.3122	.3193	.3264	.3335	.3406	.3477	.3548
24	150	1350	.3110	.3184	.3258	.3332	.3406	.3480	.3554	.3628	.3702
25	144	1296	.3240	.3317	.3394	.3471	.3548	.3625	.3702	.3779	.3856
26	138	1246	.3369	.3449	.3530	.3610	.3690	.3770	.3850	.3930	.4010
27	133	1200	.3499	.3582	.3667	.3749	.3832	.3915	.3998	.4081	.4164
28	129	1157	.3628	.3714	.3801	.3888	.3974	.4060	.4146	.4232	.4319
29	124	1117	.3758	.3847	.3937	.4026	.4116	.4205	.4294	.4384	.4473
30	120	1080	.3887	.3980	.4073	.4165	.4258	.4350	.4442	.4535	.4627
31	116	1045	.4017	.4112	.4209	.4304	.4400	.4495	.4590	.4686	.4781
32	112	1012	.4147	.4245	.4344	.4443	.4541	.4640	.4739	.4837	.4936
33	109	982	.4276	.4378	.4480	.4582	.4683	.4785	.4887	.4988	.5090
34	106	953	.4406	.4510	.4616	.4721	.4825	.4930	.5035	.5139	.5244
35	103	926	.4535	.4643	.4752	.4859	.4967	.5075	.5183	.5291	.5398
36	100	900	.4665	.4776	.4887	.4998	.5109	.5220	.5331	.5442	.5553
37	97	876	.4794	.4908	.5023	.5137	.5251	.5365	.5479	.5593	.5707
38	95	852	.4924	.5041	.5159	.5276	.5393	.5510	.5627	.5744	.5861
39	92	831	.5054	.5174	.5295	.5415	.5535	.5655	.5775	.5895	.6015
40	90	810	.5183	.5306	.5430	.5554	.5677	.5800	.5923	.6046	.6170
41	88	790	.5313	.5439	.5566	.5692	.5819	.5945	.6071	.6198	.6324
42	86	771	.5442	.5572	.5702	.5831	.5961	.6090	.6219	.6349	.6478
43	84	753	.5572	.5704	.5838	.5970	.6103	.6235	.6367	.6500	.6632
44	82	736	.5702	.5837	.5973	.6109	.6244	.6380	.6516	.6651	.6787
45	80	720	.5831	.5970	.6109	.6248	.6386	.6525	.6664	.6802	.6941
46	78	704	.5961	.6102	.6245	.6387	.6528	.6670	.6813	.6953	.7095
47	76	689	.6090	.6235	.6381	.6525	.6670	.6815	.6960	.7105	.7249
48	75	675	.6220	.6368	.6516	.6664	.6812	.6960	.7108	.7256	.7404
49	73	661	.6349	.6500	.6652	.6803	.6954	.7105	.7256	.7407	.7558
50	72	648	.6479	.6633	.6788	.6942	.7096	.7250	.7404	.7558	.7712
51	71	635	.6609	.6766	.6924	.7081	.7238	.7395	.7552	.7709	.7866
52	69	623	.6738	.6898	.7060	.7220	.7380	.7540	.7700	.7860	.8020
53	68	611	.6868	.7031	.7195	.7359	.7522	.7685	.7848	.8011	.8175
54	67	600	.6997	.7164	.7331	.7497	.7664	.7830	.7996	.8163	.8329
55	65	589	.7127	.7296	.7467	.7637	.7806	.7975	.8144	.8314	.8483
56	64	578	.7256	.7429	.7603	.7775	.7948	.8120	.8292	.8465	.8637
57	63	568	.7386	.7562	.7738	.7914	.8089	.8265	.8441	.8616	.8792
58	62	558	.7516	.7694	.7874	.8053	.8231	.8410	.8589	.8767	.8946
59	61	549	.7645	.7827	.8010	.8192	.8373	.8555	.8737	.8918	.9100
60	60	540	.7775	.7960	.8146	.8330	.8515	.8700	.8885	.9070	.9254

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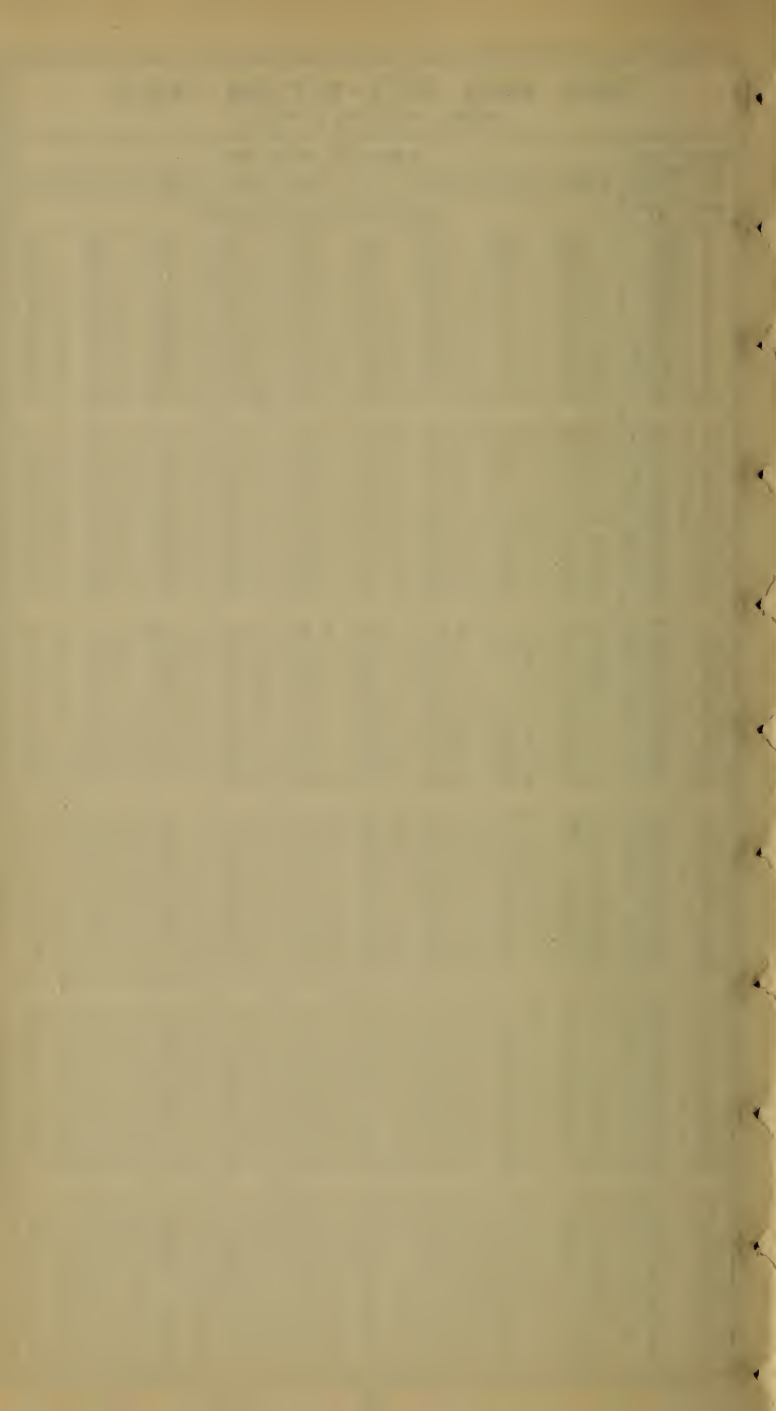
Chapter XXIX

Chapter XXX

PIECE WORK RATE-SETTING TABLE

NINE HOURS A DAY

Minutes to do One Piece	No. of Pieces in Nine Hours	AMOUNT PER DAY								
		1.50	1.60	1.70	1.75	1.80	1.90	2.00	2.10	2.25
		RATE PER 100 PIECES								
1	540	.28	.30	.32	.33	.34	.35	.37	.39	.42
2	270	.56	.59	.63	.65	.67	.70	.74	.78	.83
3	180	.83	.89	.94	.97	1.00	1.06	1.11	1.17	1.25
4	135	1.11	1.19	1.26	1.30	1.33	1.41	1.48	1.56	1.67
5	108	1.39	1.48	1.57	1.62	1.67	1.76	1.85	1.94	2.08
6	90	1.67	1.78	1.89	1.94	2.00	2.11	2.22	2.33	2.50
7	77.1	1.94	2.07	2.20	2.27	2.33	2.46	2.59	2.72	2.92
8	67.5	2.22	2.37	2.52	2.59	2.67	2.81	2.96	3.11	3.33
9	60	2.50	2.67	2.83	2.92	3.00	3.17	3.33	3.50	3.75
10	54	2.78	2.96	3.15	3.24	3.33	3.52	3.70	3.89	4.17
11	49.1	3.06	3.26	3.46	3.56	3.67	3.87	4.07	4.28	4.58
12	45	3.33	3.56	3.78	3.89	4.00	4.22	4.44	4.67	5.00
13	41.5	3.61	3.85	4.09	4.21	4.33	4.57	4.81	5.06	5.42
14	38.6	3.89	4.15	4.41	4.54	4.67	4.93	5.19	5.44	5.83
15	36	4.17	4.44	4.72	4.86	5.00	5.28	5.56	5.83	6.25
16	33.7	4.44	4.74	5.04	5.18	5.33	5.63	5.93	6.22	6.67
17	31.8	4.72	5.04	5.35	5.51	5.67	5.98	6.30	6.61	7.08
18	30	5.00	5.33	5.67	5.83	6.00	6.33	6.67	7.00	7.50
19	28.4	5.28	5.63	5.98	6.16	6.33	6.68	7.04	7.39	7.91
20	27	5.55	5.93	6.30	6.48	6.67	7.04	7.41	7.78	8.33
21	25.7	5.83	6.22	6.61	6.80	7.00	7.39	7.78	8.17	8.75
22	24.5	6.11	6.52	6.93	7.13	7.33	7.74	8.15	8.55	9.17
23	23.5	6.39	6.81	7.24	7.45	7.67	8.09	8.52	8.94	9.58
24	22.5	6.67	7.11	7.56	7.78	8.00	8.44	8.89	9.33	10.00
25	21.6	6.94	7.41	7.87	8.10	8.33	8.80	9.26	9.72	10.42
26	20.8	7.22	7.70	8.19	8.43	8.67	9.15	9.63	10.11	10.83
27	20	7.50	8.00	8.50	8.75	9.00	9.50	10.00	10.50	11.25
28	19.3	7.78	8.30	8.81	9.07	9.33	9.85	10.37	10.89	11.67
29	18.6	8.05	8.59	9.13	9.40	9.67	10.20	10.74	11.28	12.08
30	18	8.33	8.89	9.44	9.72	10.00	10.56	11.11	11.67	12.50
31	17.4	8.61	9.18	9.76	10.05	10.33	10.91	11.48	12.05	12.91
32	16.9	8.89	9.48	10.07	10.37	10.67	11.26	11.85	12.44	13.33
33	16.4	9.17	9.78	10.39	10.69	11.00	11.61	12.22	12.83	13.75
34	15.9	9.44	10.07	10.70	11.02	11.33	11.96	12.59	13.22	14.17
35	15.4	9.72	10.37	11.02	11.34	11.67	12.31	12.96	13.61	14.58
36	15	10.00	10.67	11.33	11.67	12.00	12.67	13.33	14.00	15.00
37	14.6	10.28	10.96	11.65	12.00	12.33	13.02	13.70	14.39	15.42
38	14.2	10.55	11.26	11.96	12.31	12.67	13.37	14.07	14.78	15.83
39	13.8	10.83	11.55	12.28	12.64	13.00	13.72	14.44	15.17	16.25
40	13.5	11.11	11.85	12.59	12.96	13.33	14.07	14.82	15.55	16.67
41	13.2	11.39	12.15	12.91	13.29	13.67	14.43	15.19	15.94	17.08
42	12.9	11.67	12.44	13.22	13.61	14.00	14.78	15.56	16.33	17.50
43	12.6	11.94	12.74	13.54	13.93	14.33	15.13	15.93	16.72	17.92
44	12.3	12.22	13.04	13.85	14.26	14.67	15.48	16.30	17.10	18.33
45	12	12.50	13.33	14.17	14.58	15.00	15.83	16.67	17.50	18.75
46	11.7	12.78	13.63	14.48	14.91	15.33	16.18	17.04	17.89	19.17
47	11.5	13.05	13.93	14.80	15.23	15.67	16.54	17.41	18.28	19.58
48	11.3	13.33	14.22	15.11	15.55	16.00	16.89	17.78	18.67	20.00
49	11	13.61	14.52	15.43	15.88	16.33	17.24	18.15	19.05	20.42
50	10.8	13.89	14.81	15.74	16.20	16.67	17.59	18.52	19.44	20.83
51	10.6	14.16	15.11	16.06	16.53	17.00	17.94	18.89	19.83	21.25
52	10.4	14.44	15.41	16.37	16.85	17.33	18.30	19.26	20.22	21.67
53	10.2	14.72	15.70	16.69	17.18	17.67	18.65	19.63	20.61	22.08
54	10	15.00	16.00	17.00	17.50	18.00	19.00	20.00	21.00	22.50
55	9.8	15.28	16.30	17.32	17.82	18.33	19.35	20.37	21.39	22.92
56	9.6	15.55	16.59	17.63	18.15	18.67	19.70	20.74	21.78	23.33
57	9.5	15.83	16.89	17.94	18.47	19.00	20.05	21.11	22.17	23.75
58	9.3	16.11	17.18	18.26	18.80	19.33	20.41	21.48	22.55	24.17
59	9.2	16.39	17.48	18.57	19.12	19.67	20.76	21.85	22.94	24.58
60	9	16.66	17.78	18.89	19.44	20.00	21.11	22.22	23.33	25.00



PIECE WORK RATE-SETTING TABLE

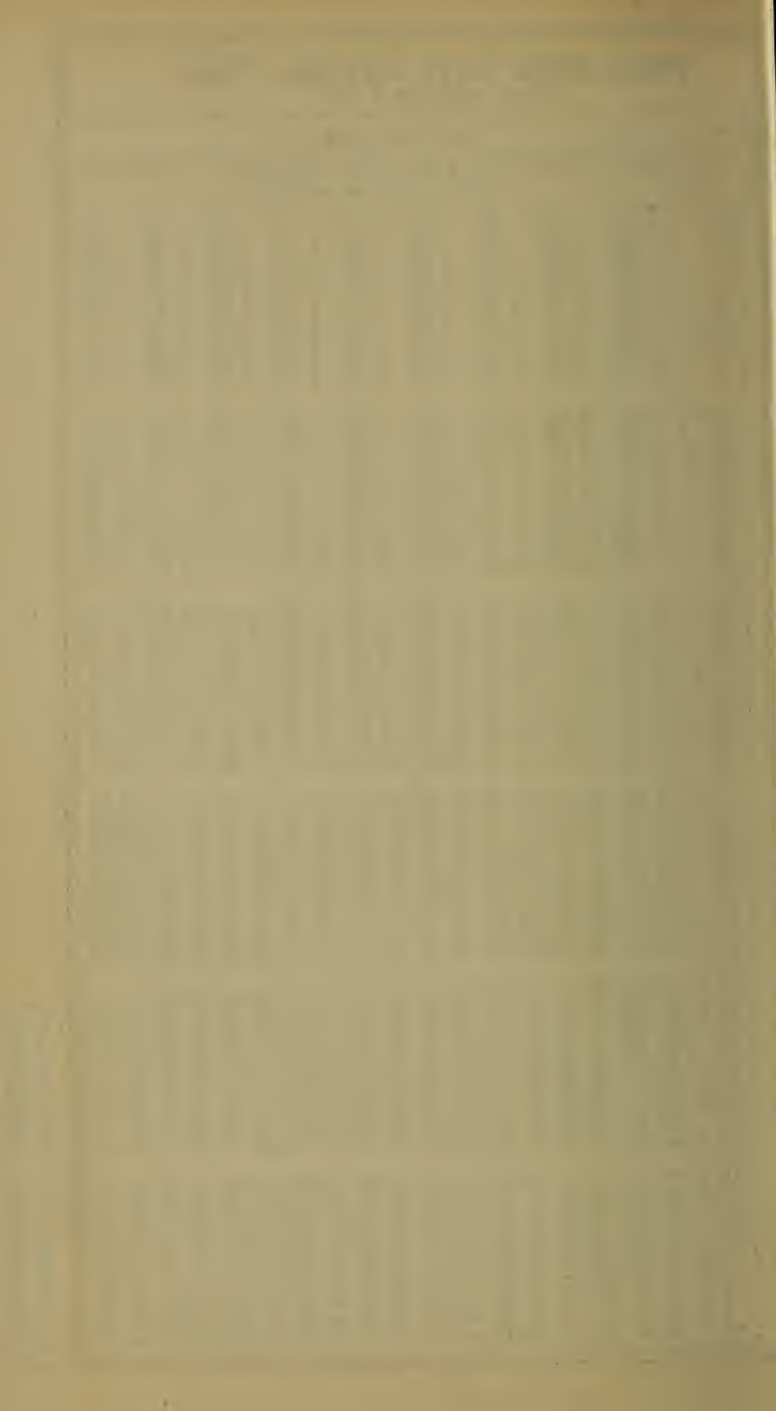
NINE HOURS A DAY

Minutes to do One Piece	No. of Pieces in Nine Hours	AMOUNT PER DAY								
		2.40	2.50	2.60	2.75	2.80	2.90	3.00	3.10	3.20
		RATE PER 100 PIECES								
1	540	.44	.46	.48	.51	.52	.54	.56	.57	.59
2	270	.89	.93	.96	1.02	1.04	1.07	1.11	1.15	1.19
3	180	1.33	1.39	1.44	1.53	1.56	1.61	1.67	1.72	1.78
4	135	1.78	1.85	1.93	2.04	2.07	2.15	2.22	2.30	2.37
5	108	2.22	2.31	2.41	2.55	2.59	2.69	2.78	2.87	2.96
6	90	2.67	2.78	2.89	3.06	3.11	3.22	3.33	3.44	3.56
7	77.1	3.11	3.24	3.37	3.56	3.63	3.76	3.89	4.02	4.15
8	67.5	3.56	3.70	3.85	4.07	4.15	4.30	4.44	4.59	4.74
9	60	4.00	4.17	4.33	4.58	4.67	4.83	5.00	5.17	5.33
10	54	4.44	4.63	4.82	5.09	5.19	5.37	5.56	5.74	5.93
11	49.1	4.89	5.09	5.30	5.60	5.70	5.91	6.11	6.31	6.52
12	45	5.33	5.56	5.78	6.11	6.22	6.44	6.67	6.89	7.11
13	41.5	5.78	6.02	6.26	6.62	6.74	6.98	7.22	7.46	7.70
14	38.6	6.22	6.48	6.74	7.13	7.26	7.52	7.78	8.04	8.30
15	36	6.67	6.94	7.22	7.64	7.78	8.06	8.33	8.61	8.89
16	33.7	7.11	7.41	7.70	8.15	8.30	8.59	8.89	9.18	9.48
17	31.8	7.56	7.87	8.19	8.66	8.81	9.13	9.44	9.76	10.07
18	30	8.00	8.33	8.67	9.17	9.33	9.67	10.00	10.33	10.67
19	28.4	8.44	8.80	9.15	9.68	9.85	10.20	10.56	10.91	11.26
20	27	8.89	9.26	9.63	10.18	10.37	10.74	11.11	11.48	11.85
21	25.7	9.33	9.72	10.11	10.69	10.89	11.28	11.67	12.05	12.45
22	24.5	9.78	10.19	10.59	11.20	11.41	11.82	12.22	12.63	13.04
23	23.5	10.22	10.65	11.07	11.71	11.93	12.35	12.78	13.20	13.63
24	22.5	10.67	11.11	11.56	12.22	12.44	12.89	13.33	13.78	14.22
25	21.6	11.11	11.57	12.04	12.73	12.96	13.43	13.89	14.35	14.82
26	20.8	11.55	12.04	12.52	13.24	13.48	13.96	14.44	14.92	15.41
27	20	12.00	12.50	13.00	13.75	14.00	14.50	15.00	15.50	16.00
28	19.3	12.44	12.96	13.48	14.26	14.52	15.04	15.56	16.07	16.59
29	18.6	12.89	13.43	13.96	14.77	15.04	15.57	16.11	16.65	17.19
30	18	13.33	13.89	14.45	15.28	15.56	16.11	16.67	17.22	17.78
31	17.4	13.78	14.35	14.93	15.79	16.07	16.65	17.22	17.79	18.37
32	16.9	14.22	14.81	15.41	16.30	16.59	17.19	17.78	18.37	18.96
33	16.4	14.67	15.28	15.89	16.80	17.11	17.72	18.33	18.94	19.56
34	15.9	15.11	15.74	16.37	17.31	17.63	18.26	18.89	19.52	20.15
35	15.4	15.55	16.20	16.85	17.82	18.15	18.80	19.44	20.09	20.74
36	15	16.00	16.67	17.33	18.33	18.67	19.33	20.00	20.66	21.33
37	14.6	16.44	17.13	17.82	18.84	19.19	19.87	20.55	21.24	21.93
38	14.2	16.89	17.59	18.30	19.35	19.70	20.41	21.11	21.81	22.52
39	13.8	17.33	18.06	18.78	19.86	20.22	20.95	21.67	22.39	23.11
40	13.5	17.78	18.52	19.26	20.37	20.74	21.48	22.22	22.96	23.70
41	13.2	18.22	18.98	19.74	20.88	21.26	22.02	22.78	23.53	24.30
42	12.9	18.67	19.44	20.22	21.39	21.78	22.56	23.33	24.11	24.89
43	12.6	19.11	19.91	20.70	21.90	22.30	23.09	23.89	24.68	25.48
44	12.3	19.55	20.37	21.19	22.41	22.81	23.63	24.44	25.26	26.08
45	12	20.00	20.83	21.67	22.91	23.33	24.17	25.00	25.83	26.67
46	11.7	20.44	21.30	22.15	23.42	23.85	24.70	25.55	26.40	27.26
47	11.5	20.89	21.75	22.63	23.93	24.37	25.24	26.11	26.98	27.85
48	11.3	21.33	22.22	23.11	24.44	24.89	25.78	26.67	27.55	28.45
49	11	21.78	22.69	23.59	24.95	25.41	26.32	27.22	28.13	29.04
50	10.8	22.22	23.15	24.08	25.46	25.93	26.85	27.78	28.70	29.63
51	10.6	22.67	23.61	24.56	25.97	26.44	27.39	28.33	29.28	30.22
52	10.4	23.11	24.07	25.04	26.48	26.96	27.93	28.89	29.85	30.82
53	10.2	23.55	24.54	25.52	26.99	27.48	28.46	29.44	30.42	31.41
54	10	24.00	25.00	26.00	27.50	28.00	29.00	30.00	31.00	32.00
55	9.8	24.44	25.46	26.48	28.01	28.52	29.54	30.55	31.57	32.59
56	9.6	24.89	25.93	26.96	28.52	29.04	30.08	31.11	32.15	33.19
57	9.5	25.33	26.39	27.45	29.03	29.56	30.61	31.67	32.72	33.78
58	9.3	25.78	26.85	27.93	29.53	30.07	31.15	32.22	33.29	34.37
59	9.2	26.22	27.31	28.41	30.04	30.59	31.69	32.78	33.87	34.96
60	9	26.67	27.78	28.89	30.55	31.11	32.22	33.33	34.44	35.56

PIECE WORK RATE-SETTING TABLE

NINE HOURS A DAY

Minutes to do One Piece	No. of Pieces in Nine Hours	AMOUNT PER DAY								
		3.30	3.40	3.50	3.60	3.70	3.80	3.90	4.00	4.10
		RATE PER 100 PIECES								
1	540	.61	.63	.65	.67	.69	.71	.72	.74	.76
2	270	1.22	1.26	1.30	1.33	1.37	1.41	1.44	1.48	1.52
3	180	1.83	1.89	1.94	2.00	2.06	2.11	2.17	2.22	2.28
4	135	2.44	2.52	2.59	2.67	2.74	2.81	2.89	2.96	3.04
5	108	3.06	3.15	3.24	3.33	3.43	3.52	3.61	3.70	3.79
6	90	3.67	3.78	3.89	4.00	4.11	4.22	4.33	4.44	4.55
7	77.1	4.28	4.41	4.54	4.67	4.80	4.92	5.05	5.18	5.31
8	67.5	4.89	5.04	5.18	5.33	5.48	5.63	5.78	5.92	6.07
9	60	5.50	5.67	5.83	6.00	6.17	6.33	6.50	6.66	6.83
10	54	6.11	6.30	6.48	6.67	6.85	7.04	7.22	7.40	7.59
11	49.1	6.72	6.93	7.13	7.33	7.54	7.74	7.94	8.15	8.35
12	45	7.33	7.55	7.78	8.00	8.22	8.44	8.66	8.89	9.11
13	41.5	7.94	8.18	8.42	8.68	8.91	9.15	9.39	9.63	9.87
14	38.6	8.56	8.81	9.07	9.33	9.59	9.85	10.11	10.37	10.63
15	36	9.17	9.44	9.72	10.00	10.28	10.55	10.83	11.11	11.38
16	33.7	9.78	10.07	10.37	10.66	10.96	11.26	11.55	11.85	12.14
17	31.8	10.39	10.70	11.02	11.33	11.65	11.96	12.27	12.59	12.90
18	30	11.00	11.33	11.67	12.00	12.33	12.66	13.00	13.33	13.66
19	28.4	11.61	11.96	12.31	12.66	13.02	13.67	13.72	14.07	14.42
20	27	12.22	12.59	12.96	13.33	13.70	14.07	14.44	14.81	15.18
21	25.7	12.83	13.22	13.61	14.00	14.39	14.77	15.16	15.59	15.94
22	24.5	13.44	13.85	14.26	14.66	15.07	15.48	15.88	16.29	16.70
23	23.5	14.06	14.48	14.91	15.33	15.76	16.18	16.61	17.03	17.46
24	22.5	14.67	15.11	15.55	16.00	16.44	16.88	17.33	17.77	18.21
25	21.6	15.28	15.74	16.20	16.66	17.13	17.59	18.05	18.51	18.97
26	20.8	15.89	16.37	16.85	17.33	17.81	18.29	18.77	19.25	19.73
27	20	16.50	17.00	17.50	18.00	18.50	18.99	19.49	19.99	20.49
28	19.3	17.11	17.63	18.15	18.66	19.18	19.70	20.21	20.73	21.25
29	18.6	17.72	18.26	18.79	19.33	19.87	20.40	20.94	21.47	22.01
30	18	18.33	18.89	19.44	20.00	20.55	21.11	21.66	22.21	22.77
31	17.4	18.94	19.52	20.09	20.66	21.24	21.81	22.38	22.95	23.53
32	16.9	19.56	20.15	20.74	21.33	21.92	22.51	23.10	23.69	24.29
33	16.4	20.17	20.78	21.39	22.00	22.60	23.22	23.83	24.44	25.05
34	15.9	20.78	21.41	22.03	22.66	23.29	23.92	24.55	25.18	25.80
35	15.4	21.39	22.04	22.68	23.33	23.98	24.62	25.27	25.92	26.56
36	15	22.00	22.66	23.33	24.00	24.66	25.33	25.99	26.66	27.32
37	14.6	22.61	23.29	23.98	24.66	25.35	26.03	26.71	27.40	28.08
38	14.2	23.22	23.92	24.63	25.33	26.03	26.73	27.44	28.14	28.84
39	13.8	23.83	24.55	25.27	26.00	26.72	27.44	28.16	28.88	29.60
40	13.5	24.44	25.18	25.92	26.66	27.40	28.14	28.88	29.62	30.36
41	13.2	25.06	25.81	26.57	27.33	28.09	28.84	29.60	30.36	31.12
42	12.9	25.67	26.44	27.22	28.00	28.77	29.55	30.32	31.10	31.88
43	12.6	26.28	27.07	27.87	28.66	29.45	30.25	31.05	31.84	32.63
44	12.3	26.89	27.70	28.51	29.33	30.14	30.95	31.77	32.58	33.39
45	12	27.50	28.33	29.16	30.00	30.83	31.66	32.49	33.32	34.15
46	11.7	28.11	28.96	29.81	30.66	31.51	32.36	33.21	34.06	34.91
47	11.5	28.72	29.59	30.46	31.33	32.20	33.06	33.93	34.80	35.67
48	11.3	29.33	30.22	31.11	32.00	32.88	33.77	34.66	35.54	36.43
49	11	29.94	30.85	31.75	32.66	33.57	34.47	35.38	36.28	37.19
50	10.8	30.56	31.48	32.40	33.33	34.25	35.18	36.10	37.02	37.95
51	10.6	31.17	32.11	33.05	33.99	34.94	35.88	36.82	37.76	38.71
52	10.4	31.78	32.74	33.70	34.66	35.62	36.58	37.54	38.50	39.46
53	10.2	32.39	33.37	34.35	35.33	36.31	37.29	38.26	39.24	40.23
54	10	33.00	34.00	35.00	35.99	36.99	37.99	38.99	39.98	40.98
55	9.8	33.61	34.63	35.64	36.66	37.68	38.69	39.71	40.73	41.74
56	9.6	34.22	35.26	36.29	37.33	38.36	39.40	40.43	41.47	42.50
57	9.5	34.83	35.89	36.94	37.99	39.05	40.10	41.15	42.21	43.26
58	9.3	35.44	36.52	37.58	38.66	39.73	40.80	41.87	42.95	44.02
59	9.2	36.05	37.15	38.24	39.33	40.42	41.51	42.60	43.69	44.78
60	9	36.67	37.77	38.88	40.00	41.10	42.21	43.32	44.43	45.54



PIECE WORK RATE-SETTING TABLE

NINE HOURS A DAY

Minutes to do One Piece	No. of Pieces In Nine Hours	AMOUNT PER DAY								
		4.20	4.30	4.40	4.50	4.60	4.70	4.80	4.90	5.00
		RATE PER 100 PIECES								
1	540	.78	.80	.81	.83	.85	.87	.89	.91	.93
2	270	1.55	1.59	1.63	1.67	1.70	1.74	1.78	1.81	1.85
3	180	2.33	2.39	2.44	2.50	2.55	2.61	2.66	2.72	2.78
4	135	3.11	3.18	3.26	3.33	3.41	3.48	3.55	3.63	3.70
5	108	3.89	3.98	4.07	4.16	4.26	4.35	4.44	4.53	4.63
6	90	4.66	4.78	4.89	5.00	5.11	5.22	5.33	5.44	5.55
7	77.1	5.44	5.57	5.70	5.83	5.96	6.09	6.22	6.35	6.48
8	67.5	6.22	6.37	6.52	6.66	6.81	6.96	7.11	7.25	7.40
9	60	7.00	7.16	7.33	7.50	7.66	7.83	7.99	8.16	8.33
10	54	7.77	7.96	8.14	8.33	8.51	8.70	8.88	9.07	9.25
11	49.1	8.55	8.75	8.96	9.16	9.36	9.57	9.77	9.97	10.18
12	45	9.33	9.55	9.77	9.99	10.22	10.44	10.66	10.88	11.10
13	41.5	10.11	10.35	10.59	10.83	11.07	11.31	11.55	11.79	12.03
14	38.6	10.88	11.14	11.40	11.66	11.92	12.18	12.44	12.69	12.95
15	36	11.66	11.94	12.22	12.49	12.77	13.05	13.33	13.60	13.88
16	33.7	12.44	12.73	13.03	13.33	13.62	13.92	14.21	14.51	14.80
17	31.8	13.22	13.53	13.84	14.16	14.47	14.79	15.10	15.42	15.73
18	30	13.99	14.33	14.66	14.99	15.32	15.66	15.99	16.32	16.65
19	28.4	14.77	15.12	15.47	15.82	16.18	16.53	16.88	17.23	17.58
20	27	15.55	15.92	16.29	16.66	17.03	17.40	17.77	18.14	18.51
21	25.7	16.33	16.71	17.10	17.49	17.88	18.27	18.65	19.04	19.43
22	24.5	17.10	17.51	17.92	18.32	18.73	19.14	19.54	19.95	20.36
23	23.5	17.88	18.31	18.73	19.16	19.58	20.01	20.43	20.86	21.28
24	22.5	18.66	19.10	19.55	19.99	20.43	20.88	21.32	21.76	22.21
25	21.6	19.44	19.90	20.36	20.82	21.28	21.75	22.21	22.67	23.13
26	20.8	20.21	20.69	21.17	21.65	22.13	22.62	23.10	23.58	24.06
27	20	20.99	21.49	21.99	22.49	22.99	23.49	23.98	24.48	24.98
28	19.3	21.77	22.29	22.80	23.32	23.84	24.35	24.87	25.39	25.91
29	18.6	22.55	23.08	23.62	24.15	24.69	25.22	25.76	26.30	26.83
30	18	23.32	23.88	24.43	24.99	25.54	26.09	26.65	27.20	27.76
31	17.4	24.10	24.67	25.25	25.82	26.39	26.96	27.54	28.11	28.68
32	16.9	24.88	25.47	26.06	26.65	27.24	27.83	28.43	29.02	29.61
33	16.4	25.65	26.26	26.87	27.48	28.09	28.70	29.31	29.92	30.53
34	15.9	26.43	27.06	27.69	28.32	28.95	29.57	30.20	30.83	31.46
35	15.4	27.21	27.86	28.50	29.15	29.80	30.44	31.09	31.74	32.38
36	15	27.99	28.65	29.32	29.98	30.65	31.31	31.98	32.64	33.31
37	14.6	28.76	29.45	30.13	30.82	31.50	32.18	32.87	33.55	34.23
38	14.2	29.54	30.24	30.95	31.65	32.35	33.05	33.76	34.46	35.16
39	13.8	30.31	31.04	31.76	32.48	33.20	33.92	34.64	35.36	36.09
40	13.5	31.10	31.84	32.58	33.31	34.05	34.79	35.53	36.27	37.01
41	13.2	31.87	32.63	33.39	34.15	34.90	35.66	36.42	37.18	37.94
42	12.9	32.65	33.43	34.20	34.98	35.76	36.53	37.31	38.08	38.86
43	12.6	33.43	34.22	35.02	35.81	36.61	37.40	38.20	38.99	39.79
44	12.3	34.21	35.02	35.83	36.65	37.46	38.27	39.09	39.90	40.71
45	12	34.98	35.82	36.65	37.48	38.31	39.14	39.97	40.81	41.64
46	11.7	35.76	36.61	37.46	38.31	39.16	40.01	40.86	41.71	42.56
47	11.5	36.54	37.41	38.28	39.14	40.01	40.88	41.75	42.62	43.49
48	11.3	37.32	38.20	39.09	39.98	40.86	41.75	42.64	43.53	44.41
49	11	38.09	39.00	39.90	40.81	41.72	42.62	43.53	44.43	45.34
50	10.8	38.87	39.80	40.72	41.64	42.57	43.49	44.42	45.34	46.26
51	10.6	39.65	40.59	41.53	42.48	43.42	44.36	45.30	46.25	47.19
52	10.4	40.43	41.39	42.35	43.31	44.27	45.23	46.19	47.15	48.11
53	10.2	41.20	42.18	43.16	44.14	45.12	46.10	47.08	48.06	49.04
54	10	41.98	42.98	43.98	44.97	45.97	46.97	47.97	48.97	49.96
55	9.8	42.76	43.77	44.79	45.81	46.82	47.84	48.86	49.87	50.89
56	9.6	43.54	44.57	45.61	46.64	47.68	48.71	49.74	50.78	51.81
57	9.5	44.31	45.37	46.42	47.47	48.53	49.58	50.63	51.69	52.74
58	9.3	45.09	46.16	47.23	48.31	49.38	50.45	51.52	52.59	53.67
59	9.2	45.87	46.96	48.05	49.14	50.23	51.32	52.41	53.50	54.59
60	9	46.65	47.75	48.85	49.97	51.08	52.19	53.30	54.41	55.52

PIECE WORK RATE-SETTING TABLE

NINE HOURS A DAY

Hours to do One Piece	No. of Pieces in 9 Hours	AMOUNT PER DAY						
		1.50	1.60	1.75	1.80	1.90	2.00	2.10
		RATE PER 100 PIECES						
1	9	16.66	17.78	19.44	20.00	21.11	22.22	23.33
2	4½	33.33	35.55	38.89	40.00	42.22	44.44	46.66
3	3	49.99	53.33	58.33	60.00	63.33	66.66	69.99
4	2½	66.66	71.11	77.77	80.00	84.44	88.88	93.32
5	1¾	83.32	88.88	97.22	100.00	105.55	111.10	116.65
6	1½	99.99	106.66	116.66	120.00	126.66	133.32	139.98
7	1⅓	116.65	124.44	136.11	140.00	147.77	155.54	163.31
8	1¼	133.32	142.21	155.55	160.00	168.88	177.76	186.64
9	1	150.00	160.00	175.00	180.00	190.00	200.00	210.00

Hours to do One Piece	No. of Pieces in 9 Hours	AMOUNT PER DAY						
		2.25	2.40	2.50	2.60	2.75	2.80	2.90
		RATE PER 100 PIECES						
1	9	25.00	26.67	27.78	28.89	30.55	31.11	32.22
2	4½	50.00	53.34	55.56	57.78	61.10	62.22	64.44
3	3	75.00	80.01	83.34	86.67	91.65	93.33	96.66
4	2½	100.00	106.68	111.12	115.56	122.20	124.44	128.88
5	1¾	125.00	133.35	138.90	144.45	152.75	155.55	161.10
6	1½	150.00	160.02	166.68	173.34	183.30	186.66	193.32
7	1⅓	175.00	186.69	194.46	202.23	213.85	217.77	225.54
8	1¼	200.00	213.36	222.24	231.12	244.40	248.88	257.76
9	1	225.00	240.00	250.00	260.00	275.00	280.00	290.00

Hours to do One Piece	No. of Pieces in 9 Hours	AMOUNT PER DAY						
		3.00	3.10	3.20	3.30	3.40	3.50	3.60
		RATE PER 100 PIECES						
1	9	33.33	34.44	35.56	36.67	37.37	38.38	40.00
2	4½	66.66	68.88	71.12	73.34	75.54	77.76	80.00
3	3	99.99	103.32	106.68	110.01	113.31	116.64	120.00
4	2½	133.32	137.76	142.24	146.68	151.08	155.52	160.00
5	1¾	166.65	172.20	177.80	183.35	188.85	194.40	200.00
6	1½	199.98	206.64	213.36	220.02	226.62	233.28	240.00
7	1⅓	233.31	241.08	248.92	256.69	264.39	272.16	280.00
8	1¼	266.64	275.52	284.48	293.36	302.16	311.04	320.00
9	1	300.00	310.00	320.00	330.00	340.00	350.00	360.00

Hours to do One Piece	No. of Pieces in 9 Hours	AMOUNT PER DAY						
		3.70	3.80	3.90	4.00	4.10	4.20	4.30
		RATE PER 100 PIECES						
1	9	41.10	42.21	43.32	44.43	45.54	46.65	47.75
2	4½	82.20	84.42	86.64	88.86	91.08	93.30	95.50
3	3	123.30	126.63	129.96	133.29	136.62	139.95	143.25
4	2½	164.40	168.84	173.28	177.72	182.16	186.60	191.00
5	1¾	205.50	211.05	216.60	222.15	227.70	233.25	238.75
6	1½	246.60	253.26	259.92	266.58	273.24	279.90	286.50
7	1⅓	287.70	295.47	303.24	311.01	318.78	326.55	334.25
8	1¼	328.80	337.68	346.56	355.44	364.32	373.20	382.00
9	1	370.00	380.00	390.00	400.00	410.00	420.00	430.00

Hours to do One Piece	No. of Pieces in 9 Hours	AMOUNT PER DAY						
		4.40	4.50	4.60	4.70	4.80	4.90	5.00
		RATE PER 100 PIECES						
1	9	48.86	49.97	51.08	52.19	53.30	54.41	55.52
2	4½	97.72	99.94	102.16	104.38	106.60	108.82	111.04
3	3	146.58	149.91	153.24	156.57	159.90	163.23	166.56
4	2½	195.44	199.88	204.32	208.76	213.20	217.64	222.08
5	1¾	244.30	249.85	255.40	260.95	266.50	272.05	277.60
6	1½	293.16	299.82	306.48	313.14	319.80	326.46	333.12
7	1⅓	342.02	349.79	357.56	365.33	373.10	380.87	388.64
8	1¼	390.88	399.76	408.64	417.52	426.40	435.28	444.16
9	1	440.00	450.00	460.00	470.00	480.00	490.00	500.00

PIECE - FINDING TABLE — TEN HOURS

SHOWING NUMBER OF PIECES WHEN TIME REQUIRED TO
DO ONE PIECE IS OVER ONE MINUTE

Sec.	1 Min.	2 Min.	3 Min.	4 Min.	5 Min.	6 Min.	7 Min.	8 Min.	9 Min.	10 Min.	11 Min.	12 Min.
1	600	300	200	150	120	100	85.7	75	66.7	60	54.5	50
2	591	297	199	150	120	99.7	85.5	74.8	66.5	59.9	54.4	49.9
3	580	295	198	149	120	99.5	85.3	74.7	66.4	59.8	54.3	49.8
4	571	293	197	149	119	99.2	85.1	74.5	66.3	59.7	54.2	49.8
5	562	290	195	148	119	99	84.9	74.4	66.2	59.6	54.2	49.7
6	554	287	194	148	119	98.7	84.8	74.2	66.1	59.5	54.1	49.6
7	545	285	193	147	118	98.5	84.6	74.1	66	59.4	54	49.6
8	537	283	192	147	118	98.2	84.4	74	65.9	59.3	53.9	49.5
9	529	281	191	146	118	98	84.2	73.8	65.7	59.2	53.9	49.4
	521	279	190	146	117	97.8	84.1	73.7	65.6	59.1	53.8	49.4
10	514	277	189	145	117	97.5	83.9	73.5	65.5	59	53.7	49.3
11	507	274	188	145	117	97.3	83.7	73.4	65.4	59	53.6	49.2
12	500	272	187	144	116	97	83.5	73.3	65.3	58.9	53.6	49.2
13	495	270	186	144	116	96.8	83.3	73.1	65.2	58.8	53.5	49.1
14	493	268	185	143	116	96.5	83.2	73	65.1	58.7	53.4	49
15	480	266	184	143	115	96.3	83	72.9	64.9	58.6	53.3	48.9
16	473	264	183	142	115	96.1	82.8	72.8	64.8	58.5	53.3	48.9
17	467	262	182	142	115	95.8	82.6	72.7	64.7	58.4	53.2	48.8
18	461	260	181	141	114	95.6	82.5	72.5	64.6	58.3	53.1	48.7
19	456	258	181	141	114	95.3	82.3	72.4	64.5	58.2	53	48.7
20	450	257	180	140	114	95.1	82.1	72.2	64.4	58.1	53	48.6
21	444	255	179	140	113	94.8	81.9	72.1	64.3	58	52.9	48.5
22	439	253	178	139	113	94.6	81.7	71.9	64.2	57.9	52.8	48.5
23	434	251	177	139	113	94.4	81.6	71.7	64	57.8	52.8	48.4
24	428	250	176	138	112	94.1	81.4	71.6	63.9	57.8	52.8	48.4
25	423	249	176	138	112	93.9	81.2	71.4	63.8	57.7	52.7	48.3
26	416	247	175	137	112	93.6	81	71.3	63.7	57.6	52.6	48.2
27	413	245	174	137	111	93.4	80.9	71.1	63.6	57.5	52.5	48.2
28	409	243	173	136	111	93.1	80.7	71	63.5	57.4	52.5	48.1
29	404	242	172	136	111	92.9	80.5	70.9	63.4	57.3	52.4	48
30	400	240	171	135	110	92.7	80.3	70.7	63.2	57.2	52.3	48
31	396	238	171	135	110	92.4	80.1	70.6	63.1	57.1	52.2	47.9
32	391	236	170	134	110	92.2	80	70.4	63	57	52.2	47.8
33	387	235	169	134	109	91.9	79.8	70.3	62.9	56.9	52.1	47.8
34	383	233	168	133	109	91.7	79.6	70.1	62.8	56.8	52	47.7
35	379	232	167	133	109	91.4	79.4	70	62.7	56.7	51.9	47.6
36	375	230	167	132	108	91.2	79.3	69.9	62.6	56.7	51.9	47.6
37	371	229	166	132	108	91	79.1	69.7	62.4	56.6	51.8	47.5
38	367	228	165	131	108	90.7	78.9	69.6	62.3	56.5	51.7	47.4
39	363	227	164	131	107	90.5	78.7	69.4	62.2	56.4	51.6	47.4
40	360	225	164	130	107	90.2	78.5	69.3	62.1	56.3	51.6	47.3
41	356	223	163	130	107	90	78.4	69.2	62	56.2	51.5	47.2
42	353	222	162	129	106	89.7	78.2	69	61.9	56.1	51.4	47.2
43	350	221	161	129	106	89.5	78	68.9	61.8	56	51.3	47.1
44	346	219	161	128	106	89.3	77.8	68.7	61.7	55.9	51.3	47
45	343	218	160	128	105	89	77.7	68.6	61.5	55.8	51.2	46.9
46	339	217	159	127	105	88.8	77.5	68.5	61.4	55.7	51.1	46.9
47	336	216	159	127	105	88.5	77.3	68.3	61.3	55.7	51	46.8
48	333	214	158	126	104	88.3	77.1	68.2	61.2	55.6	51	46.7
49	330	213	157	126	104	88.1	76.9	68	61.1	55.5	50.9	46.6
50	327	211	157	125	104	87.8	76.8	67.9	61	55.4	50.8	46.6
51	324	210	156	125	103	87.6	76.6	67.7	60.9	55.3	50.7	46.5
52	321	208	155	124	103	87.3	76.4	67.6	60.7	55.2	50.7	46.4
53	318	207	155	124	103	87.1	76.2	67.5	60.6	55.1	50.6	46.4
54	316	206	154	123	102	86.8	76	67.3	60.5	55	50.5	46.3
55	312	205	153	123	102	86.6	75.9	67.2	60.4	54.9	50.4	46.3
56	310	204	153	122	102	86.4	75.5	67.1	60.3	54.8	50.4	46.2
57	307	203	152	122	101	86.1	75.3	67	60.2	54.7	50.3	46.2
58	305	202	151	121	101	85.9	75.2	66.9	60.1	54.7	50.2	46.1
59	302	201	151	121	101	85.7	75.1	66.8	60	54.6	50.1	46.1

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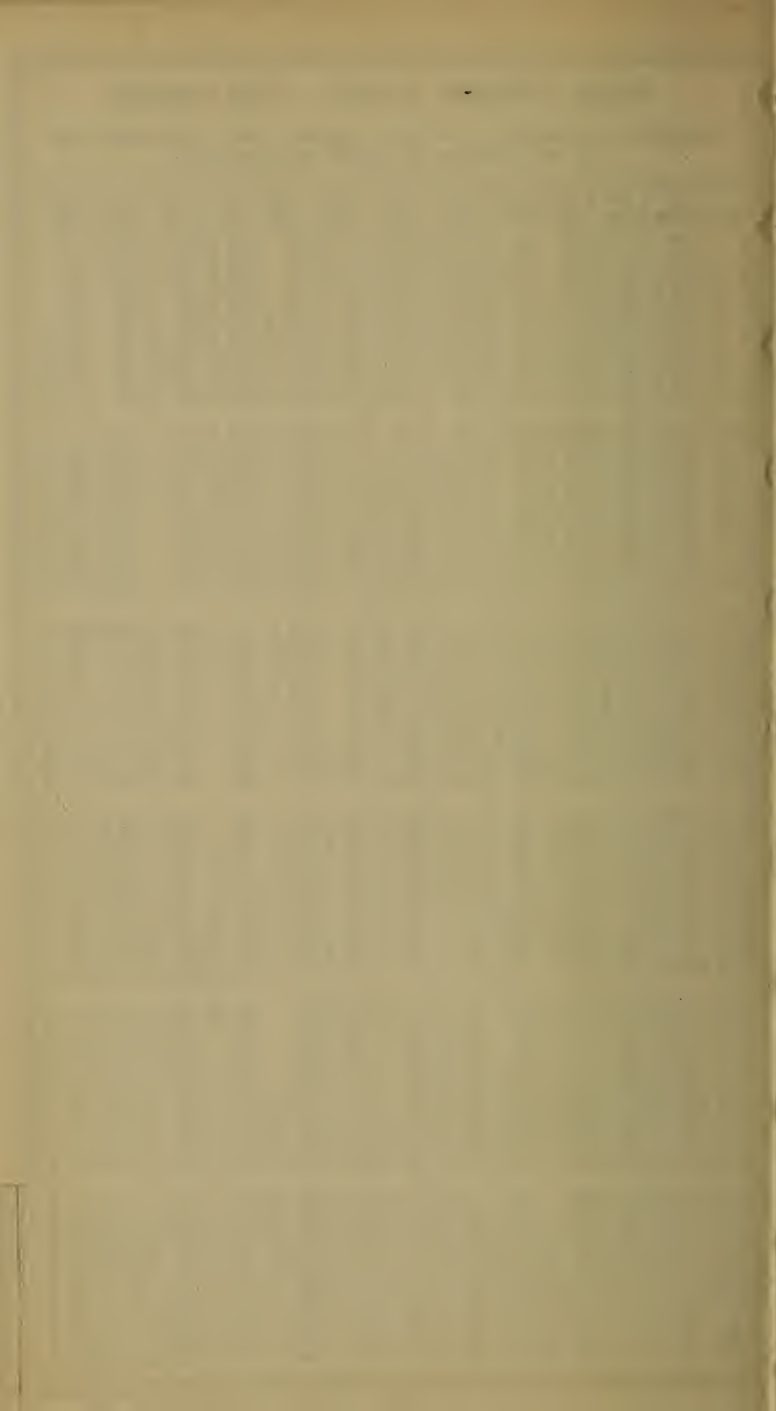
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PIECE - FINDING TABLE — TEN HOURS

SHOWING NUMBER OF PIECES WHEN TIME REQUIRED TO
DO ONE PIECE IS OVER ONE MINUTE

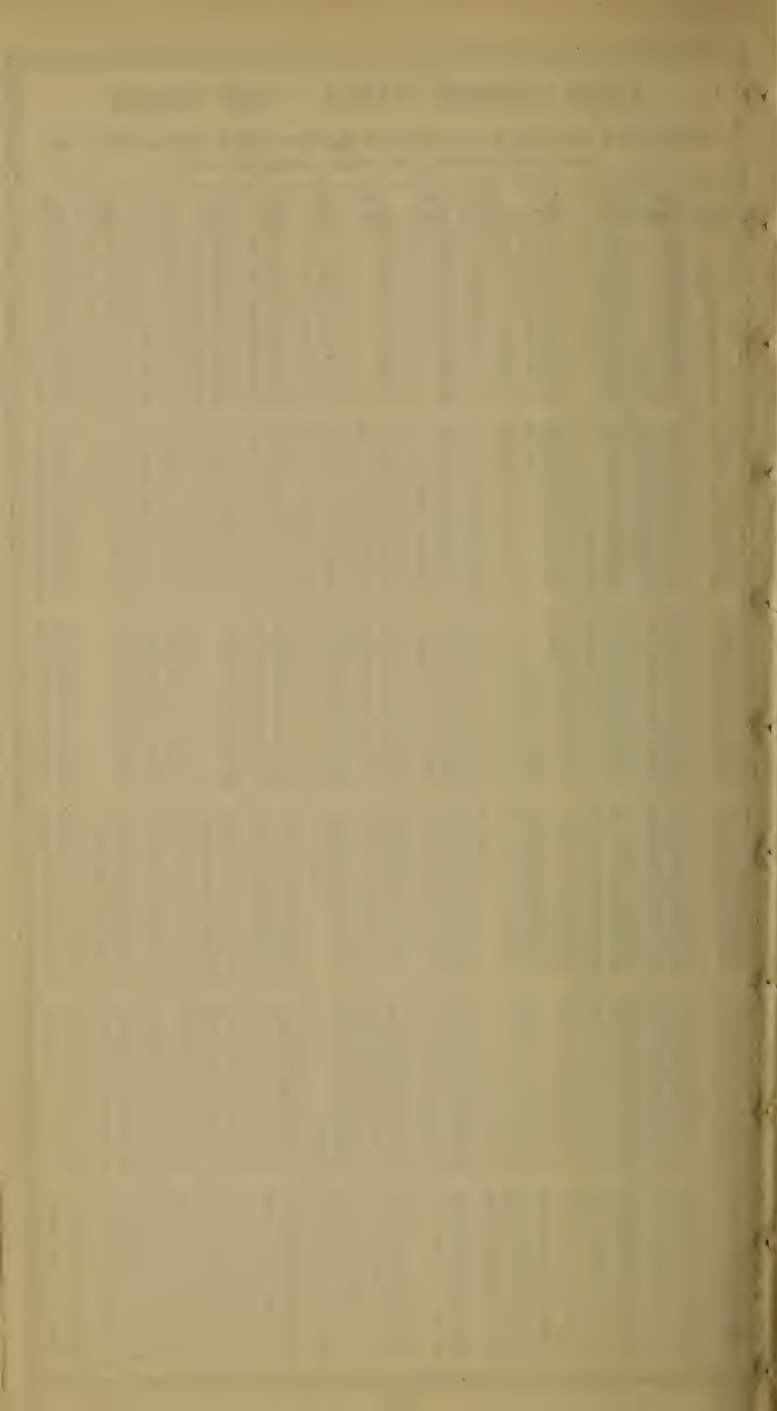
Sec.	13 Min.	14 Min.	15 Min.	16 Min.	17 Min.	18 Min.	19 Min.	20 Min.	21 Min.	22 Min.	23 Min.	24 Min.
1	46.1	42.8	40	37.5	35.3	33.3	31.6	30	28.6	27.3	26.1	25
2	46	42.8	40	37.5	35.3	33.3	31.6	30	28.6	27.3	26.1	25
3	45.9	42.7	40	37.5	35.3	33.3	31.6	30	28.6	27.3	26.1	25
4	45.9	42.7	40	37.4	35.2	33.2	31.6	30	28.6	27.3	26.1	25
5	45.8	42.6	39.9	37.4	35.2	33.2	31.5	29.9	28.6	27.3	26.1	25
6	45.8	42.6	39.9	37.4	35.2	33.2	31.5	29.9	28.5	27.2	26	25
7	45.7	42.5	39.9	37.3	35.1	33.1	31.5	29.9	28.5	27.2	26	24.9
8	45.7	42.5	39.8	37.3	35.1	33.1	31.5	29.9	28.5	27.2	26	24.9
9	45.6	42.4	39.8	37.2	35.1	33.1	31.4	29.8	28.5	27.2	26	24.9
	45.6	42.4	39.8	37.2	35	33.1	31.4	29.8	28.4	27.2	26	24.9
10	45.5	42.3	39.7	37.2	35	33	31.4	29.8	28.4	27.1	26	24.9
11	45.4	42.3	39.7	37.1	35	33	31.3	29.8	28.4	27.1	25.9	24.9
12	45.4	42.2	39.7	37.1	34.9	33	31.3	29.7	28.4	27.1	25.9	24.8
13	45.3	42.2	39.6	37.1	34.9	32.9	31.3	29.7	28.4	27.1	25.9	24.8
14	45.3	42.1	39.6	37	34.9	32.9	31.3	29.7	28.3	27.1	25.9	24.8
15	45.2	42.1	39.6	37	34.8	32.9	31.2	29.7	28.3	27	25.9	24.8
16	45.2	42	39.5	36.9	34.8	32.8	31.2	29.6	28.3	27	25.8	24.8
17	45.1	42	39.5	36.9	34.8	32.8	31.2	29.6	28.3	27	25.8	24.8
18	45.1	41.9	39.4	36.9	34.7	32.8	31.2	29.6	28.2	27	25.8	24.7
19	45	41.9	39.4	36.8	34.7	32.7	31.1	29.6	28.2	27	25.8	24.7
20	45	41.8	39.3	36.8	34.7	32.7	31.1	29.5	28.2	26.9	25.8	24.7
21	44.9	41.8	39.3	36.8	34.6	32.7	31.1	29.5	28.2	26.9	25.8	24.7
22	44.8	41.7	39.2	36.7	34.6	32.6	31.1	29.5	28.2	26.9	25.7	24.7
23	44.8	41.7	39.2	36.7	34.6	32.6	31	29.5	28.1	26.9	25.7	24.7
24	44.7	41.6	39.1	36.6	34.5	32.6	31	29.4	28.1	26.9	25.7	24.6
25	44.7	41.6	39.1	36.6	34.5	32.5	31	29.4	28.1	26.8	25.7	24.6
26	44.6	41.5	39	36.6	34.5	32.5	31	29.4	28.1	26.8	25.7	24.6
27	44.6	41.5	39	36.5	34.4	32.5	30.9	29.4	28.1	26.8	25.6	24.6
28	44.5	41.4	38.9	36.5	34.4	32.4	30.9	29.3	28	26.8	25.6	24.6
29	44.5	41.4	38.9	36.4	34.4	32.4	30.9	29.3	28	26.8	25.6	24.6
30	44.4	41.3	38.9	36.4	34.3	32.4	30.8	29.3	28	26.7	25.6	24.5
31	44.3	41.3	38.8	36.4	34.3	32.4	30.8	29.3	28	26.7	25.6	24.5
32	44.3	41.2	38.8	36.3	34.3	32.3	30.8	29.2	27.9	26.7	25.6	24.5
33	44.2	41.2	38.8	36.3	34.2	32.3	30.8	29.2	27.9	26.7	25.5	24.5
34	44.2	41.1	38.7	36.3	34.2	32.3	30.7	29.2	27.9	26.7	25.5	24.5
35	44.1	41.1	38.7	36.2	34.2	32.2	30.7	29.2	27.9	26.6	25.5	24.5
36	44.1	41	38.7	36.2	34.1	32.2	30.7	29.1	27.9	26.6	25.5	24.4
37	44	41	38.6	36.2	34.1	32.2	30.6	29.1	27.8	26.6	25.5	24.4
38	44	40.9	38.6	36.1	34.1	32.2	30.6	29.1	27.8	26.6	25.4	24.4
39	43.9	40.9	38.6	36.1	34	32.1	30.6	29.1	27.8	26.6	25.4	24.4
40	43.9	40.8	38.5	36.1	34	32.1	30.6	29	27.8	26.5	25.4	24.4
41	43.8	40.8	38.5	36	34	32.1	30.5	29	27.7	26.5	25.4	24.4
42	43.7	40.7	38.4	36	33.9	32.1	30.5	29	27.7	26.5	25.4	24.3
43	43.7	40.7	38.4	36	33.9	32	30.5	29	27.7	26.5	25.4	24.3
44	43.6	40.6	38.3	35.9	33.9	32	30.5	29	27.7	26.5	25.3	24.3
45	43.6	40.6	38.3	35.9	33.8	32	30.4	28.9	27.7	26.4	25.3	24.3
46	43.5	40.5	38.2	35.8	33.8	32	30.4	28.9	27.6	26.4	25.3	24.3
47	43.5	40.5	38.2	35.8	33.8	31.9	30.4	28.9	27.6	26.4	25.3	24.3
48	43.4	40.4	38.1	35.8	33.7	31.9	30.4	28.9	27.6	26.4	25.3	24.2
49	43.4	40.4	38.1	35.7	33.7	31.9	30.3	28.9	27.6	26.4	25.2	24.2
50	43.3	40.4	38	35.7	33.7	31.9	30.3	28.8	27.5	26.3	25.2	24.2
51	43.2	40.3	38	35.7	33.6	31.9	30.3	28.8	27.5	26.3	25.2	24.2
52	43.2	40.3	37.9	35.6	33.6	31.8	30.3	28.8	27.5	26.3	25.2	24.2
53	43.1	40.3	37.9	35.6	33.6	31.8	30.2	28.8	27.5	26.3	25.2	24.2
54	43.1	40.2	37.8	35.6	33.5	31.8	30.2	28.8	27.5	26.2	25.2	24.1
55	43	40.2	37.8	35.5	33.5	31.8	30.2	28.7	27.4	26.2	25.1	24.1
56	43	40.2	37.7	35.5	33.5	31.7	30.2	28.7	27.4	26.2	25.1	24.1
57	42.9	40.1	37.7	35.4	33.4	31.7	30.1	28.7	27.4	26.2	25.1	24.1
58	42.9	40.1	37.6	35.4	33.4	31.7	30.1	28.7	27.4	26.2	25.1	24.1
59	42.8	40.1	37.6	35.4	33.4	31.7	30.1	28.7	27.4	26.2	25.1	24.1



PIECE - FINDING TABLE — TEN HOURS

SHOWING NUMBER OF PIECES WHEN TIME REQUIRED TO
DO ONE PIECE IS OVER ONE MINUTE

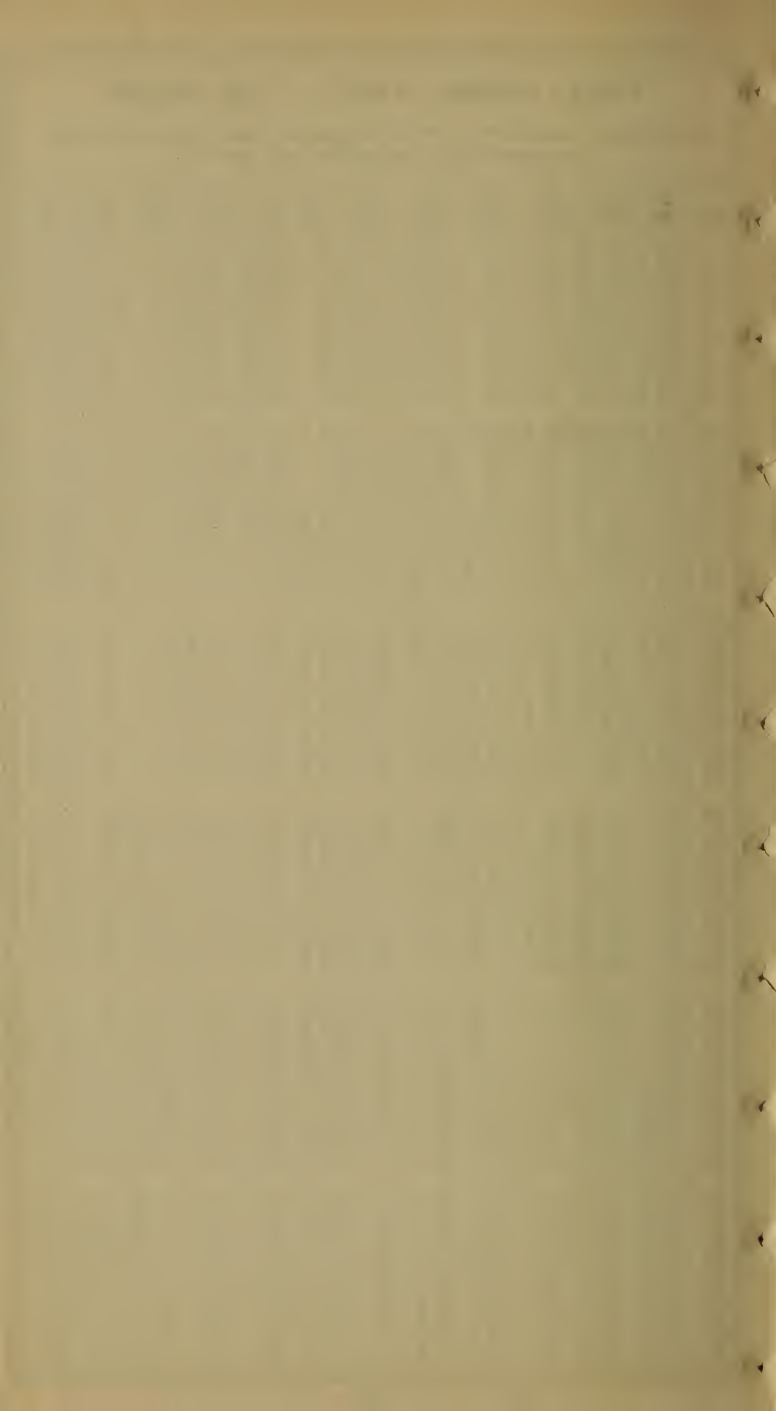
Sec.	25 Min.	26 Min.	27 Min.	28 Min.	29 Min.	30 Min.	31 Min.	32 Min.	33 Min.	34 Min.	35 Min.	36 Min.
1	24	23.1	22.2	21.4	20.7	20	19.3	18.8	18.2	17.6	17.1	16.7
2	24	23.1	22.2	21.4	20.7	20	19.3	18.8	18.2	17.6	17.1	16.7
3	24	23.1	22.2	21.4	20.7	20	19.3	18.8	18.2	17.6	17.1	16.7
4	24	23.1	22.2	21.4	20.7	20	19.3	18.8	18.2	17.6	17.1	16.7
5	24	23.1	22.2	21.4	20.7	20	19.3	18.8	18.2	17.6	17.1	16.7
6	24	23.1	22.2	21.4	20.7	20	19.3	18.8	18.2	17.6	17.1	16.7
7	23.9	23	22.1	21.4	20.7	20	19.3	18.8	18.2	17.6	17.1	16.7
8	23.9	23	22.1	21.4	20.7	20	19.3	18.8	18.2	17.6	17.1	16.7
9	23.9	23	22.1	21.3	20.6	19.9	19.3	18.8	18.2	17.6	17.1	16.7
10	23.9	23	22.1	21.3	20.6	19.9	19.3	18.7	18.1	17.6	17.1	16.7
11	23.9	23	22.1	21.3	20.6	19.9	19.3	18.7	18.1	17.6	17.1	16.7
12	23.9	23	22.1	21.3	20.6	19.9	19.2	18.7	18.1	17.5	17.1	16.6
13	23.8	22.9	22.1	21.3	20.6	19.9	19.2	18.7	18.1	17.5	17.1	16.6
14	23.8	22.9	22.1	21.3	20.6	19.9	19.2	18.7	18.1	17.5	17.1	16.6
15	23.8	22.9	22	21.3	20.6	19.9	19.2	18.7	18.1	17.5	17	16.6
16	23.8	22.9	22	21.3	20.6	19.9	19.2	18.7	18.1	17.5	17	16.6
17	23.8	22.9	22	21.2	20.5	19.8	19.2	18.7	18.1	17.5	17	16.6
18	23.8	22.9	22	21.2	20.5	19.8	19.2	18.7	18.1	17.5	17	16.6
19	23.8	22.9	22	21.2	20.5	19.8	19.2	18.7	18.1	17.5	17	16.6
20	23.7	22.8	22	21.2	20.5	19.8	19.2	18.6	18	17.5	17	16.6
21	23.7	22.8	22	21.2	20.5	19.8	19.2	18.6	18	17.5	17	16.6
22	23.7	22.8	22	21.2	20.5	19.8	19.2	18.6	18	17.5	17	16.6
23	23.7	22.8	21.9	21.2	20.5	19.8	19.2	18.6	18	17.5	17	16.6
24	23.7	22.8	21.9	21.2	20.5	19.8	19.1	18.6	18	17.4	17	16.5
25	23.7	22.8	21.9	21.1	20.4	19.7	19.1	18.6	18	17.4	17	16.5
26	23.7	22.8	21.9	21.1	20.4	19.7	19.1	18.6	18	17.4	17	16.5
27	23.6	22.7	21.9	21.1	20.4	19.7	19.1	18.6	18	17.4	17	16.5
28	23.6	22.7	21.9	21.1	20.4	19.7	19.1	18.6	18	17.4	17	16.5
29	23.6	22.7	21.9	21.1	20.4	19.7	19.1	18.6	18	17.4	17	16.5
30	23.6	22.7	21.8	21.1	20.4	19.7	19.1	18.6	17.9	17.4	17	16.5
31	23.6	22.7	21.8	21.1	20.4	19.7	19.1	18.5	17.9	17.4	16.9	16.5
32	23.6	22.7	21.8	21.1	20.4	19.7	19.1	18.5	17.9	17.4	16.9	16.5
33	23.5	22.6	21.8	21.1	20.4	19.7	19.1	18.5	17.9	17.4	16.9	16.5
34	23.5	22.6	21.8	21	20.3	19.6	19.1	18.5	17.9	17.4	16.9	16.5
35	23.5	22.6	21.8	21	20.3	19.6	19.1	18.5	17.9	17.4	16.9	16.5
36	23.5	22.6	21.8	21	20.3	19.6	19	18.5	17.9	17.3	16.9	16.4
37	23.5	22.6	21.7	21	20.3	19.6	19	18.5	17.9	17.3	16.9	16.4
38	23.5	22.6	21.7	21	20.3	19.6	19	18.5	17.9	17.3	16.9	16.4
39	23.4	22.6	21.7	21	20.3	19.6	19	18.5	17.9	17.3	16.9	16.4
40	23.4	22.5	21.7	21	20.3	19.6	19	18.4	17.8	17.3	16.9	16.4
41	23.4	22.5	21.7	21	20.3	19.6	19	18.4	17.8	17.3	16.9	16.4
42	23.4	22.5	21.7	21	20.3	19.6	19	18.4	17.8	17.3	16.9	16.4
43	23.4	22.5	21.7	20.9	20.2	19.5	19	18.4	17.8	17.3	16.9	16.4
44	23.4	22.5	21.7	20.9	20.2	19.5	19	18.4	17.8	17.3	16.9	16.4
45	23.3	22.5	21.6	20.9	20.2	19.5	19	18.4	17.8	17.3	16.8	16.4
46	23.3	22.4	21.6	20.9	20.2	19.5	19	18.4	17.8	17.3	16.8	16.4
47	23.3	22.4	21.6	20.9	20.2	19.5	19	18.4	17.8	17.3	16.8	16.4
48	23.3	22.4	21.6	20.9	20.2	19.5	18.9	18.4	17.8	17.2	16.8	16.3
49	23.3	22.4	21.6	20.9	20.2	19.5	18.9	18.4	17.8	17.2	16.8	16.3
50	23.3	22.4	21.6	20.9	20.2	19.5	18.9	18.3	17.7	17.2	16.8	16.3
51	23.3	22.4	21.6	20.8	20.1	19.4	18.9	18.3	17.7	17.2	16.8	16.3
52	23.2	22.4	21.6	20.8	20.1	19.4	18.9	18.3	17.7	17.2	16.8	16.3
53	23.2	22.3	21.5	20.8	20.1	19.4	18.9	18.3	17.7	17.2	16.8	16.3
54	23.2	22.3	21.5	20.8	20.1	19.4	18.9	18.3	17.7	17.2	16.8	16.3
55	23.2	22.3	21.5	20.8	20.1	19.4	18.9	18.3	17.7	17.2	16.8	16.3
56	23.2	22.3	21.5	20.8	20.1	19.4	18.9	18.3	17.7	17.2	16.8	16.3
57	23.2	22.3	21.5	20.8	20.1	19.4	18.9	18.3	17.7	17.2	16.8	16.3
58	23.2	22.3	21.5	20.8	20.1	19.4	18.9	18.3	17.7	17.2	16.8	16.3
59	23.2	22.3	21.5	20.8	20.1	19.4	18.9	18.3	17.7	17.2	16.8	16.3



PIECE - FINDING TABLE — TEN HOURS

SHOWING NUMBER OF PIECES WHEN TIME REQUIRED TO
DO ONE PIECE IS OVER ONE MINUTE

Sec.	37 Min.	38 Min.	39 Min.	40 Min.	41 Min.	42 Min.	43 Min.	44 Min.	45 Min.	46 Min.	47 Min.	48 Min.
1	16.2	15.8	15.4	15	14.6	14.3	14	13.6	13.3	13	12.8	12.5
2	16.2	15.8	15.4	15	14.6	14.3	14	13.6	13.3	13	12.8	12.5
3	16.2	15.8	15.4	15	14.6	14.3	14	13.6	13.3	13	12.8	12.5
4	16.2	15.8	15.4	15	14.6	14.3	14	13.6	13.3	13	12.8	12.5
5	16.2	15.8	15.4	15	14.6	14.3	14	13.6	13.3	13	12.8	12.5
6	16.2	15.8	15.4	15	14.6	14.3	14	13.6	13.3	13	12.8	12.5
7	16.2	15.8	15.4	15	14.6	14.3	14	13.6	13.3	13	12.8	12.5
8	16.2	15.8	15.4	15	14.6	14.3	14	13.6	13.3	13	12.8	12.5
9	16.2	15.8	15.4	15	14.6	14.3	14	13.6	13.3	13	12.8	12.5
10	16.2	15.8	15.4	15	14.6	14.3	14	13.6	13.3	13	12.8	12.5
11	16.2	15.8	15.4	15	14.6	14.3	14	13.6	13.3	13	12.8	12.5
12	16.2	15.8	15.4	15	14.6	14.3	14	13.6	13.3	13	12.8	12.5
13	16.2	15.8	15.4	15	14.6	14.3	14	13.6	13.3	13	12.8	12.5
14	16.2	15.8	15.4	15	14.6	14.3	14	13.6	13.3	13	12.8	12.5
15	16.1	15.7	15.3	14.9	14.6	14.3	13.9	13.6	13.3	13	12.8	12.5
16	16.1	15.7	15.3	14.9	14.6	14.3	13.9	13.6	13.3	13	12.8	12.5
17	16.1	15.7	15.3	14.9	14.6	14.3	13.9	13.6	13.3	13	12.8	12.5
18	16.1	15.7	15.3	14.9	14.6	14.3	13.9	13.6	13.3	13	12.8	12.5
19	16.1	15.7	15.3	14.9	14.6	14.3	13.9	13.6	13.3	13	12.8	12.5
20	16.1	15.7	15.3	14.9	14.5	14.2	13.9	13.5	13.2	13	12.7	12.4
21	16.1	15.7	15.3	14.9	14.5	14.2	13.9	13.5	13.2	13	12.7	12.4
22	16.1	15.7	15.3	14.9	14.5	14.2	13.9	13.5	13.2	13	12.7	12.4
23	16.1	15.7	15.3	14.9	14.5	14.2	13.9	13.5	13.2	13	12.7	12.4
24	16.1	15.7	15.3	14.9	14.5	14.2	13.9	13.5	13.2	13	12.7	12.4
25	16.1	15.7	15.3	14.9	14.5	14.2	13.9	13.5	13.2	13	12.7	12.4
26	16.1	15.7	15.3	14.9	14.5	14.2	13.9	13.5	13.2	13	12.7	12.4
27	16.1	15.7	15.3	14.9	14.5	14.2	13.9	13.5	13.2	13	12.7	12.4
28	16.1	15.7	15.3	14.9	14.5	14.2	13.9	13.5	13.2	13	12.7	12.4
29	16.1	15.7	15.3	14.9	14.5	14.2	13.9	13.5	13.2	13	12.7	12.4
30	16	15.6	15.2	14.8	14.5	14.2	13.8	13.5	13.2	12.9	12.7	12.4
31	16	15.6	15.2	14.8	14.5	14.2	13.8	13.5	13.2	12.9	12.7	12.4
32	16	15.6	15.2	14.8	14.5	14.2	13.8	13.5	13.2	12.9	12.7	12.4
33	16	15.6	15.2	14.8	14.5	14.2	13.8	13.5	13.2	12.9	12.7	12.4
34	16	15.6	15.2	14.8	14.5	14.2	13.8	13.5	13.2	12.9	12.7	12.4
35	16	15.6	15.2	14.8	14.5	14.2	13.8	13.5	13.2	12.9	12.7	12.4
36	16	15.6	15.2	14.8	14.5	14.2	13.8	13.5	13.2	12.9	12.7	12.4
37	16	15.6	15.2	14.8	14.5	14.2	13.8	13.5	13.2	12.9	12.7	12.4
38	16	15.6	15.2	14.8	14.5	14.2	13.8	13.5	13.2	12.9	12.7	12.4
39	16	15.6	15.2	14.8	14.5	14.2	13.8	13.5	13.2	12.9	12.7	12.4
40	16	15.6	15.2	14.8	14.4	14.1	13.8	13.4	13.1	12.9	12.6	12.3
41	16	15.6	15.2	14.8	14.4	14.1	13.8	13.4	13.1	12.9	12.6	12.3
42	16	15.6	15.2	14.8	14.4	14.1	13.8	13.4	13.1	12.9	12.6	12.3
43	16	15.6	15.2	14.8	14.4	14.1	13.8	13.4	13.1	12.9	12.6	12.3
44	16	15.6	15.2	14.8	14.4	14.1	13.8	13.4	13.1	12.9	12.6	12.3
45	15.9	15.5	15.1	14.7	14.4	14.1	13.7	13.4	13.1	12.9	12.6	12.3
46	15.9	15.5	15.1	14.7	14.4	14.1	13.7	13.4	13.1	12.9	12.6	12.3
47	15.9	15.5	15.1	14.7	14.4	14.1	13.7	13.4	13.1	12.9	12.6	12.3
48	15.9	15.5	15.1	14.7	14.4	14.1	13.7	13.4	13.1	12.9	12.6	12.3
49	15.9	15.5	15.1	14.7	14.4	14.1	13.7	13.4	13.1	12.9	12.6	12.3
50	15.9	15.5	15.1	14.7	14.4	14.1	13.7	13.4	13.1	12.9	12.6	12.3
51	15.9	15.5	15.1	14.7	14.4	14.1	13.7	13.4	13.1	12.9	12.6	12.3
52	15.9	15.5	15.1	14.7	14.4	14.1	13.7	13.4	13.1	12.9	12.6	12.3
53	15.9	15.5	15.1	14.7	14.4	14.1	13.7	13.4	13.1	12.9	12.6	12.3
54	15.9	15.5	15.1	14.7	14.4	14.1	13.7	13.4	13.1	12.9	12.6	12.3
55	15.9	15.5	15.1	14.7	14.4	14.1	13.7	13.4	13.1	12.9	12.6	12.3
56	15.9	15.5	15.1	14.7	14.4	14.1	13.7	13.4	13.1	12.9	12.6	12.3
57	15.9	15.5	15.1	14.7	14.4	14.1	13.7	13.4	13.1	12.9	12.6	12.3
58	15.9	15.5	15.1	14.7	14.4	14.1	13.7	13.4	13.1	12.9	12.6	12.3
59	15.9	15.5	15.1	14.7	14.4	14.1	13.7	13.4	13.1	12.9	12.6	12.3



SHOWING NUMBER OF PIECES WHEN TIME REQUIRED TO
DO ONE PIECE IS OVER ONE MINUTE

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PIECE WORK RATE-SETTING TABLE

TEN HOURS A DAY

Sec. to do One Piece	No. of Pieces in One Hour	No. of Pieces in Ten Hours	AMOUNT PER DAY								
			.75	.80	.90	1.00	1.10	1.20	1.25	1.30	1.40
			RATE PER 100 PIECES								
1	3600	36000	.0021	.0022	.0025	.0028	.0031	.0033	.0035	.0036	.0039
2	1800	18000	.0042	.0044	.0050	.0056	.0061	.0067	.0069	.0072	.0078
3	1200	12000	.0062	.0067	.0075	.0083	.0092	.0100	.0104	.0108	.0117
4	900	9000	.0083	.0089	.0100	.0111	.0122	.0133	.0139	.0144	.0156
5	720	7200	.0104	.0111	.0125	.0139	.0153	.0167	.0174	.0181	.0194
6	600	6000	.0125	.0133	.0150	.0167	.0183	.0200	.0208	.0217	.0233
7	514	5143	.0146	.0156	.0175	.0194	.0214	.0233	.0243	.0253	.0272
8	450	4500	.0167	.0178	.0200	.0222	.0244	.0267	.0278	.0289	.0311
9	400	4000	.0187	.0200	.0225	.0250	.0275	.0300	.0312	.0325	.0350
10	360	3600	.0208	.0222	.0250	.0278	.0306	.0333	.0347	.0361	.0389
11	327	3273	.0229	.0244	.0275	.0306	.0336	.0367	.0382	.0397	.0428
12	300	3000	.0250	.0267	.0300	.0333	.0367	.0400	.0417	.0433	.0467
13	277	2769	.0271	.0289	.0325	.0361	.0397	.0433	.0451	.0469	.0506
14	257	2571	.0292	.0311	.0350	.0389	.0428	.0467	.0486	.0506	.0544
15	240	2400	.0312	.0333	.0375	.0417	.0458	.0500	.0521	.0542	.0583
16	225	2250	.0333	.0356	.0400	.0444	.0489	.0533	.0556	.0578	.0622
17	212	2118	.0354	.0378	.0425	.0472	.0520	.0567	.0590	.0614	.0661
18	200	2000	.0375	.0400	.0450	.0500	.0550	.0600	.0625	.0650	.0700
19	190	1895	.0396	.0422	.0475	.0528	.0581	.0633	.0660	.0686	.0739
20	180	1800	.0417	.0444	.0500	.0556	.0611	.0667	.0694	.0722	.0778
21	171	1714	.0437	.0467	.0525	.0583	.0642	.0700	.0729	.0758	.0817
22	164	1636	.0458	.0489	.0550	.0611	.0672	.0733	.0764	.0794	.0856
23	157	1565	.0479	.0512	.0575	.0639	.0703	.0767	.0799	.0831	.0894
24	150	1500	.0500	.0533	.0600	.0667	.0733	.0800	.0833	.0867	.0933
25	144	1440	.0521	.0556	.0625	.0695	.0764	.0834	.0868	.0903	.0972
26	138	1384	.0542	.0578	.0650	.0722	.0795	.0867	.0903	.0939	.1011
27	133	1333	.0562	.0600	.0675	.0750	.0825	.0900	.0937	.0975	.1050
28	129	1285	.0583	.0622	.0700	.0778	.0856	.0934	.0972	.1011	.1089
29	124	1241	.0604	.0644	.0725	.0806	.0886	.0967	.1007	.1047	.1128
30	120	1200	.0625	.0667	.0750	.0833	.0917	.1000	.1042	.1083	.1167
31	116	1161	.0646	.0689	.0775	.0861	.0947	.1034	.1076	.1119	.1206
32	112	1125	.0667	.0711	.0800	.0889	.0998	.1067	.1111	.1156	.1244
33	109	1091	.0687	.0733	.0825	.0917	.1008	.1100	.1146	.1192	.1283
34	106	1059	.0708	.0755	.0850	.0945	.1039	.1134	.1180	.1228	.1322
35	103	1028	.0729	.0778	.0875	.0972	.1070	.1167	.1215	.1264	.1361
36	100	1000	.0750	.0800	.0900	.1000	.1100	.1200	.1250	.1300	.1400
37	97	973	.0771	.0822	.0925	.1028	.1131	.1234	.1285	.1336	.1439
38	95	947	.0792	.0844	.0950	.1056	.1161	.1267	.1319	.1372	.1478
39	92	923	.0812	.0867	.0975	.1083	.1192	.1300	.1354	.1408	.1517
40	90	900	.0833	.0889	.1000	.1111	.1222	.1334	.1389	.1444	.1556
41	88	878	.0854	.0911	.1025	.1139	.1253	.1367	.1424	.1481	.1594
42	86	857	.0875	.0933	.1050	.1167	.1284	.1400	.1458	.1517	.1633
43	84	837	.0896	.0955	.1075	.1195	.1314	.1434	.1493	.1553	.1672
44	82	818	.0917	.0978	.1100	.1222	.1345	.1467	.1528	.1589	.1711
45	80	800	.0937	.1000	.1125	.1250	.1375	.1500	.1562	.1625	.1750
46	78	782	.0958	.1022	.1150	.1278	.1406	.1534	.1597	.1661	.1789
47	76	766	.0979	.1044	.1175	.1306	.1436	.1567	.1632	.1697	.1828
48	75	750	.1000	.1067	.1200	.1333	.1467	.1600	.1667	.1733	.1867
49	73	735	.1021	.1089	.1225	.1361	.1497	.1635	.1701	.1769	.1906
50	72	720	.1042	.1111	.1250	.1389	.1528	.1667	.1736	.1806	.1945
51	71	706	.1062	.1133	.1275	.1417	.1559	.1700	.1771	.1842	.1983
52	69	692	.1083	.1155	.1300	.1445	.1589	.1734	.1805	.1878	.2022
53	68	679	.1104	.1178	.1325	.1472	.1620	.1767	.1840	.1914	.2061
54	67	666	.1125	.1200	.1350	.1500	.1650	.1800	.1875	.1950	.2100
55	65	654	.1146	.1222	.1375	.1528	.1681	.1834	.1910	.1986	.2139
56	64	642	.1166	.1244	.1400	.1556	.1711	.1867	.1944	.2022	.2178
57	63	631	.1187	.1267	.1425	.1583	.1742	.1900	.1979	.2058	.2217
58	62	621	.1208	.1289	.1450	.1611	.1772	.1934	.2014	.2094	.2256
59	61	610	.1229	.1311	.1475	.1639	.1803	.1967	.2048	.2130	.2295
60	60	600	.1250	.1333	.1500	.1667	.1834	.2000	.2083	.2167	.2333

PIECE WORK RATE-SETTING TABLE

TEN HOURS A DAY

Sec. to do One Piece	No. of Pieces in One Hour	No. of Pieces in Ten Hours	AMOUNT PER DAY								
			1.50	1.60	1.70	1.75	1.80	1.90	2.00	2.10	2.25
			RATE PER 100 PIECES								
1	3600	36000	.0042	.0044	.0047	.0049	.0050	.0053	.0056	.0058	.0063
2	1800	18000	.0083	.0089	.0094	.0097	.0100	.0106	.0111	.0117	.0125
3	1200	12000	.0125	.0133	.0142	.0146	.0150	.0158	.0167	.0175	.0188
4	900	9000	.0167	.0178	.0189	.0194	.0200	.0211	.0222	.0233	.0250
5	720	7200	.0208	.0222	.0236	.0243	.0250	.0264	.0278	.0292	.0313
6	600	6000	.0250	.0267	.0283	.0292	.0300	.0317	.0333	.0350	.0375
7	514	5143	.0291	.0311	.0331	.0340	.0350	.0369	.0389	.0408	.0438
8	450	4500	.0333	.0356	.0378	.0389	.0400	.0422	.0444	.0467	.0500
9	400	4000	.0375	.0400	.0425	.0437	.0450	.0475	.0500	.0525	.0563
10	360	3600	.0417	.0445	.0472	.0486	.0500	.0528	.0556	.0583	.0625
11	327	3273	.0458	.0489	.0520	.0535	.0550	.0580	.0611	.0642	.0688
12	300	3000	.0500	.0533	.0567	.0583	.0600	.0633	.0667	.0700	.0750
13	277	2769	.0542	.0578	.0614	.0632	.0650	.0686	.0722	.0758	.0813
14	257	2571	.0583	.0622	.0661	.0681	.0700	.0739	.0778	.0817	.0875
15	240	2400	.0625	.0667	.0708	.0729	.0750	.0792	.0833	.0875	.0938
16	225	2250	.0667	.0711	.0756	.0778	.0800	.0844	.0889	.0933	.1000
17	212	2118	.0708	.0756	.0803	.0826	.0850	.0897	.0945	.0992	.1063
18	200	2000	.0750	.0800	.0850	.0875	.0900	.0950	.1000	.1050	.1125
19	190	1895	.0792	.0845	.0897	.0924	.0950	.1003	.1056	.1108	.1188
20	180	1800	.0833	.0889	.0945	.0972	.1000	.1056	.1111	.1167	.1250
21	171	1714	.0875	.0933	.0992	.1021	.1050	.1108	.1167	.1225	.1313
22	164	1636	.0917	.0978	.1039	.1069	.1100	.1161	.1222	.1283	.1375
23	157	1565	.0958	.1022	.1086	.1118	.1150	.1214	.1278	.1342	.1438
24	150	1500	.1000	.1067	.1134	.1167	.1200	.1267	.1333	.1400	.1500
25	144	1440	.1042	.1111	.1181	.1215	.1250	.1320	.1389	.1459	.1563
26	138	1384	.1083	.1156	.1228	.1264	.1300	.1372	.1445	.1517	.1625
27	133	1333	.1125	.1200	.1275	.1312	.1350	.1425	.1500	.1575	.1688
28	129	1285	.1167	.1245	.1322	.1361	.1400	.1478	.1556	.1634	.1750
29	124	1241	.1208	.1289	.1370	.1410	.1450	.1531	.1611	.1692	.1813
30	120	1200	.1250	.1334	.1417	.1458	.1500	.1583	.1667	.1750	.1875
31	116	1161	.1292	.1378	.1464	.1507	.1550	.1636	.1722	.1809	.1938
32	112	1125	.1333	.1422	.1511	.1556	.1600	.1689	.1778	.1867	.2000
33	109	1091	.1375	.1467	.1559	.1604	.1650	.1742	.1833	.1925	.2063
34	106	1059	.1417	.1511	.1606	.1653	.1700	.1795	.1889	.1984	.2135
35	103	1028	.1458	.1556	.1653	.1701	.1750	.1847	.1945	.2042	.2198
36	100	1000	.1500	.1600	.1700	.1750	.1800	.1900	.2000	.2100	.2250
37	97	973	.1542	.1645	.1748	.1799	.1850	.1953	.2056	.2159	.2313
38	95	947	.1583	.1689	.1795	.1847	.1900	.2006	.2111	.2217	.2375
39	92	923	.1625	.1734	.1842	.1896	.1950	.2058	.2167	.2275	.2438
40	90	900	.1667	.1778	.1889	.1944	.2000	.2111	.2222	.2334	.2500
41	88	878	.1708	.1822	.1936	.1993	.2050	.2164	.2278	.2392	.2563
42	86	857	.1750	.1867	.1984	.2042	.2100	.2217	.2334	.2450	.2625
43	84	837	.1792	.1911	.2031	.2090	.2150	.2270	.2389	.2509	.2688
44	82	818	.1833	.1956	.2078	.2139	.2200	.2322	.2445	.2567	.2750
45	80	800	.1875	.2000	.2125	.2187	.2250	.2375	.2500	.2625	.2813
46	78	782	.1917	.2045	.2173	.2236	.2300	.2428	.2556	.2684	.2875
47	76	766	.1958	.2089	.2220	.2286	.2350	.2481	.2611	.2742	.2938
48	75	750	.2000	.2134	.2267	.2333	.2400	.2533	.2667	.2800	.3000
49	73	735	.2042	.2178	.2314	.2382	.2450	.2586	.2722	.2859	.3063
50	72	720	.2084	.2223	.2362	.2432	.2500	.2639	.2778	.2917	.3125
51	71	706	.2125	.2267	.2409	.2479	.2550	.2692	.2834	.2975	.3188
52	69	692	.2167	.2311	.2456	.2528	.2600	.2745	.2888	.3034	.3250
53	68	679	.2209	.2356	.2503	.2576	.2650	.2797	.2945	.3092	.3313
54	67	666	.2250	.2400	.2550	.2625	.2700	.2850	.3000	.3150	.3375
55	65	654	.2292	.2445	.2598	.2674	.2750	.2903	.3056	.3209	.3438
56	64	642	.2334	.2489	.2645	.2722	.2800	.2956	.3111	.3267	.3500
57	63	631	.2375	.2534	.2692	.2771	.2850	.3008	.3167	.3325	.3563
58	62	621	.2417	.2578	.2739	.2819	.2900	.3061	.3222	.3384	.3625
59	61	610	.2459	.2623	.2787	.2868	.2950	.3114	.3278	.3442	.3688
60	60	600	.2500	.2667	.2834	.2917	.3000	.3167	.3334	.3500	.3750

PIECE WORK RATE-SETTING TABLE

TEN HOURS A DAY

Sec. to do One Piece	No. of Pieces in One Hour	No. of Pieces in Ten Hours	AMOUNT PER DAY								
			2.40	2.50	2.60	2.75	2.80	2.90	3.00	3.10	3.20
			RATE PER 100 PIECES								
1	3600	36000	.0067	.0069	.0072	.0076	.0078	.0081	.0083	.0086	.0089
2	1800	18000	.0133	.0139	.0144	.0153	.0156	.0161	.0167	.0172	.0178
3	1200	12000	.0200	.0208	.0217	.0229	.0233	.0242	.0250	.0258	.0267
4	900	9000	.0267	.0278	.0289	.0306	.0311	.0322	.0333	.0344	.0356
5	720	7200	.0333	.0347	.0361	.0382	.0389	.0403	.0417	.0431	.0444
6	600	6000	.0400	.0417	.0433	.0458	.0467	.0483	.0500	.0517	.0533
7	514	5143	.0467	.0486	.0506	.0535	.0544	.0564	.0583	.0603	.0622
8	450	4500	.0533	.0556	.0578	.0611	.0622	.0644	.0667	.0689	.0711
9	400	4000	.0600	.0625	.0650	.0688	.0700	.0725	.0750	.0775	.0800
10	360	3600	.0667	.0694	.0722	.0764	.0778	.0806	.0833	.0861	.0889
11	327	3273	.0733	.0764	.0794	.0840	.0855	.0886	.0917	.0947	.0978
12	300	3000	.0800	.0833	.0867	.0917	.0933	.0967	.1000	.1033	.1067
13	277	2769	.0867	.0903	.0939	.0993	.1011	.1047	.1083	.1119	.1156
14	257	2571	.0933	.0972	.1011	.1069	.1089	.1128	.1167	.1206	.1244
15	240	2400	.1000	.1042	.1083	.1146	.1167	.1208	.1250	.1292	.1333
16	225	2250	.1067	.1111	.1156	.1222	.1244	.1289	.1333	.1378	.1422
17	212	2118	.1133	.1180	.1228	.1299	.1322	.1369	.1417	.1464	.1511
18	200	2000	.1200	.1250	.1300	.1375	.1400	.1450	.1500	.1550	.1600
19	190	1895	.1267	.1319	.1372	.1451	.1478	.1530	.1583	.1636	.1689
20	180	1800	.1333	.1389	.1444	.1528	.1555	.1611	.1667	.1722	.1778
21	171	1714	.1400	.1458	.1517	.1604	.1633	.1692	.1750	.1808	.1867
22	164	1636	.1467	.1528	.1589	.1681	.1711	.1772	.1833	.1894	.1956
23	157	1565	.1533	.1597	.1661	.1757	.1789	.1853	.1917	.1981	.2044
24	150	1500	.1600	.1667	.1733	.1833	.1866	.1933	.2000	.2067	.2133
25	144	1440	.1667	.1736	.1806	.1910	.1944	.2014	.2083	.2153	.2222
26	138	1384	.1733	.1805	.1878	.1986	.2022	.2094	.2167	.2239	.2311
27	133	1333	.1800	.1875	.1950	.2063	.2100	.2175	.2250	.2325	.2400
28	129	1285	.1866	.1944	.2022	.2139	.2178	.2255	.2333	.2411	.2489
29	124	1241	.1933	.2014	.2094	.2215	.2255	.2336	.2417	.2497	.2578
30	120	1200	.2000	.2083	.2167	.2292	.2333	.2417	.2500	.2583	.2667
31	116	1161	.2066	.2153	.2239	.2368	.2411	.2497	.2583	.2669	.2756
32	112	1125	.2133	.2222	.2311	.2444	.2489	.2578	.2667	.2756	.2844
33	109	1091	.2200	.2292	.2383	.2521	.2566	.2658	.2750	.2842	.2933
34	106	1059	.2266	.2361	.2455	.2597	.2644	.2739	.2833	.2928	.3022
35	103	1028	.2333	.2430	.2528	.2674	.2722	.2819	.2917	.3014	.3111
36	100	1000	.2400	.2500	.2600	.2750	.2800	.2900	.3000	.3100	.3200
37	97	973	.2466	.2569	.2672	.2826	.2877	.2980	.3083	.3186	.3289
38	95	947	.2533	.2639	.2744	.2903	.2955	.3061	.3167	.3272	.3378
39	92	923	.2600	.2708	.2817	.2979	.3033	.3141	.3250	.3358	.3467
40	90	900	.2666	.2778	.2889	.3056	.3111	.3222	.3333	.3440	.3556
41	88	878	.2733	.2847	.2961	.3132	.3189	.3303	.3417	.3531	.3644
42	86	857	.2800	.2916	.3033	.3208	.3266	.3383	.3500	.3617	.3733
43	84	837	.2866	.2986	.3105	.3285	.3344	.3464	.3583	.3703	.3822
44	82	818	.2933	.3055	.3178	.3361	.3422	.3544	.3667	.3789	.3911
45	80	800	.3000	.3125	.3250	.3438	.3500	.3625	.3750	.3875	.4000
46	78	782	.3066	.3194	.3322	.3514	.3577	.3705	.3833	.3961	.4089
47	76	765	.3133	.3264	.3394	.3590	.3655	.3786	.3917	.4047	.4178
48	75	750	.3200	.3333	.3467	.3667	.3733	.3866	.4000	.4133	.4267
49	73	735	.3266	.3403	.3538	.3743	.3811	.3947	.4083	.4219	.4356
50	72	720	.3333	.3472	.3611	.3820	.3889	.4028	.4167	.4306	.4445
51	71	706	.3400	.3541	.3683	.3896	.3966	.4108	.4250	.4392	.4533
52	69	692	.3466	.3611	.3755	.3972	.4044	.4189	.4333	.4478	.4622
53	68	679	.3533	.3680	.3828	.4049	.4122	.4269	.4416	.4564	.4711
54	67	666	.3600	.3750	.3900	.4125	.4200	.4350	.4500	.4650	.4800
55	65	654	.3666	.3819	.3972	.4201	.4277	.4430	.4583	.4736	.4889
56	64	642	.3733	.3889	.4044	.4278	.4355	.4511	.4666	.4822	.4976
57	63	631	.3800	.3958	.4117	.4354	.4433	.4591	.4750	.4908	.5067
58	62	621	.3866	.4028	.4189	.4431	.4511	.4672	.4833	.4994	.5156
59	61	610	.3933	.4097	.4261	.4507	.4588	.4752	.4916	.5080	.5245
60	60	600	.4000	.4166	.4333	.4583	.4666	.4833	.5000	.5167	.5333

PIECE WORK RATE-SETTING TABLE

TEN HOURS A DAY

Sec. to do One Piece	No. of Pieces in One Hour	No. of Pieces in Ten Hours	AMOUNT PER DAY								
			3.30	3.40	3.50	3.60	3.70	3.80	3.90	4.00	4.10
			RATE PER 100 PIECES								
1	3600	36000	.0092	.0094	.0097	.0100	.0103	.0106	.0108	.0111	.0114
2	1800	18000	.0183	.0189	.0194	.0200	.0206	.0211	.0217	.0222	.0228
3	1200	12000	.0275	.0283	.0292	.0300	.0308	.0317	.0325	.0333	.0342
4	900	9000	.0367	.0378	.0389	.0400	.0411	.0422	.0433	.0444	.0456
5	720	7200	.0458	.0472	.0486	.0500	.0514	.0528	.0542	.0555	.0569
6	600	6000	.0550	.0567	.0583	.0600	.0617	.0633	.0650	.0666	.0683
7	514	5143	.0642	.0661	.0680	.0700	.0719	.0739	.0758	.0777	.0797
8	450	4500	.0733	.0755	.0778	.0800	.0822	.0844	.0867	.0888	.0911
9	400	4000	.0825	.0850	.0875	.0900	.0925	.0950	.0975	.0999	.1025
10	360	3600	.0917	.0944	.0972	.1000	.1028	.1056	.1083	.1111	.1139
11	327	3273	.1008	.1039	.1069	.1100	.1130	.1161	.1192	.1222	.1253
12	300	3000	.1100	.1133	.1167	.1200	.1233	.1267	.1300	.1333	.1367
13	277	2769	.1191	.1228	.1264	.1300	.1336	.1372	.1408	.1444	.1481
14	257	2571	.1283	.1322	.1361	.1400	.1439	.1478	.1517	.1555	.1594
15	240	2400	.1375	.1416	.1458	.1500	.1542	.1583	.1625	.1667	.1708
16	225	2250	.1466	.1511	.1555	.1600	.1644	.1689	.1733	.1778	.1822
17	212	2118	.1558	.1605	.1653	.1700	.1747	.1794	.1842	.1889	.1936
18	200	2000	.1650	.1700	.1750	.1800	.1850	.1900	.1950	.2000	.2050
19	190	1895	.1741	.1794	.1847	.1900	.1953	.2004	.2058	.2111	.2164
20	180	1800	.1833	.1889	.1944	.2000	.2055	.2111	.2167	.2222	.2278
21	171	1714	.1925	.1983	.2041	.2100	.2158	.2217	.2275	.2333	.2392
22	164	1636	.2016	.2077	.2139	.2200	.2261	.2322	.2383	.2444	.2506
23	157	1565	.2108	.2172	.2236	.2300	.2364	.2428	.2492	.2556	.2619
24	150	1500	.2200	.2266	.2333	.2400	.2466	.2533	.2600	.2667	.2733
25	144	1440	.2291	.2361	.2430	.2500	.2569	.2639	.2708	.2778	.2847
26	138	1384	.2383	.2455	.2527	.2600	.2672	.2744	.2817	.2889	.2961
27	133	1333	.2475	.2550	.2625	.2700	.2775	.2850	.2925	.3000	.3075
28	129	1285	.2566	.2644	.2722	.2800	.2878	.2955	.3033	.3111	.3189
29	124	1241	.2658	.2738	.2819	.2900	.2980	.3061	.3142	.3222	.3303
30	120	1200	.2750	.2833	.2916	.3000	.3083	.3167	.3250	.3333	.3417
31	116	1161	.2841	.2937	.3014	.3100	.3186	.3272	.3358	.3444	.3531
32	112	1125	.2933	.3022	.3111	.3200	.3289	.3378	.3467	.3556	.3644
33	109	1091	.3024	.3116	.3208	.3300	.3391	.3483	.3575	.3667	.3758
34	106	1059	.3116	.3211	.3305	.3400	.3494	.3589	.3683	.3778	.3872
35	103	1028	.3208	.3305	.3402	.3500	.3597	.3694	.3792	.3889	.3986
36	100	1000	.3299	.3399	.3500	.3600	.3700	.3800	.3900	.4000	.4100
37	97	973	.3391	.3494	.3597	.3700	.3802	.3905	.4008	.4111	.4214
38	95	947	.3483	.3588	.3694	.3800	.3905	.4011	.4117	.4222	.4328
39	92	923	.3574	.3683	.3791	.3900	.4008	.4116	.4225	.4333	.4442
40	90	900	.3666	.3777	.3888	.4000	.4111	.4222	.4333	.4444	.4556
41	88	878	.3758	.3872	.3986	.4100	.4214	.4328	.4442	.4556	.4669
42	86	857	.3849	.3966	.4083	.4200	.4316	.4433	.4550	.4667	.4783
43	84	837	.3941	.4060	.4180	.4300	.4419	.4539	.4658	.4778	.4897
44	82	818	.4033	.4155	.4277	.4400	.4522	.4644	.4767	.4889	.5011
45	80	800	.4124	.4249	.4374	.4500	.4625	.4750	.4875	.5000	.5125
46	78	782	.4216	.4344	.4472	.4600	.4727	.4855	.4983	.5111	.5239
47	76	766	.4308	.4438	.4569	.4700	.4830	.4961	.5092	.5222	.5353
48	75	750	.4399	.4533	.4666	.4800	.4933	.5066	.5200	.5333	.5467
49	73	735	.4491	.4627	.4763	.4900	.5036	.5172	.5308	.5444	.5581
50	72	720	.4583	.4722	.4861	.5000	.5139	.5278	.5417	.5556	.5695
51	71	706	.4674	.4816	.4958	.5100	.5241	.5383	.5525	.5667	.5808
52	69	692	.4766	.4910	.5055	.5200	.5344	.5489	.5633	.5778	.5922
53	68	679	.4857	.5005	.5152	.5300	.5447	.5594	.5741	.5889	.6036
54	67	666	.4949	.5099	.5249	.5400	.5550	.5700	.5850	.6000	.6150
55	65	654	.5041	.5194	.5347	.5500	.5652	.5805	.5958	.6111	.6264
56	64	642	.5132	.5288	.5444	.5600	.5755	.5911	.6066	.6222	.6378
57	63	631	.5224	.5383	.5541	.5700	.5858	.6016	.6175	.6333	.6492
58	62	621	.5316	.5477	.5638	.5800	.5961	.6122	.6283	.6444	.6606
59	61	610	.5407	.5571	.5735	.5900	.6063	.6227	.6391	.6556	.6720
60	60	600	.5499	.5666	.5833	.6000	.6166	.6333	.6500	.6667	.6833

THE HISTORY OF THE UNITED STATES

OF THE

REPUBLIC

OF AMERICA

BY

JOHN F. JOHNSON

OF THE

UNITED STATES

OF AMERICA

AND

OF THE

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PIECE WORK RATE-SETTING TABLE

TEN HOURS A DAY

Sec. to do One Piece	No. of Pieces in One Hour	No. of Pieces in Ten Hours	AMOUNT PER DAY									
			4.20	4.30	4.40	4.50	4.60	4.70	4.80	4.90	5.00	
			RATE PER 100 PIECES									
1	3600	36000	.0117	.0119	.0122	.0125	.0128	.0131	.0133	.0136	.0139	
2	1800	18000	.0233	.0239	.0244	.0250	.0256	.0261	.0267	.0272	.0278	
3	1200	12000	.0350	.0358	.0367	.0375	.0383	.0392	.0400	.0408	.0417	
4	900	9000	.0467	.0478	.0489	.0500	.0511	.0522	.0533	.0545	.0556	
5	720	7200	.0583	.0597	.0611	.0625	.0640	.0653	.0667	.0681	.0695	
6	600	6000	.0700	.0717	.0733	.0750	.0767	.0783	.0800	.0817	.0833	
7	514	5143	.0817	.0836	.0856	.0875	.0895	.0914	.0933	.0953	.0972	
8	450	4500	.0933	.0956	.0978	.1000	.1022	.1045	.1067	.1089	.1111	
9	400	4000	.1050	.1075	.1100	.1125	.1150	.1175	.1200	.1225	.1250	
10	360	3600	.1167	.1195	.1222	.1250	.1278	.1306	.1334	.1361	.1389	
11	327	3273	.1283	.1314	.1345	.1375	.1406	.1436	.1467	.1497	.1528	
12	300	3000	.1400	.1433	.1467	.1500	.1533	.1567	.1600	.1634	.1667	
13	277	2769	.1517	.1553	.1589	.1625	.1661	.1697	.1734	.1770	.1806	
14	257	2571	.1633	.1672	.1711	.1750	.1789	.1828	.1867	.1906	.1945	
15	240	2400	.1750	.1792	.1833	.1875	.1917	.1959	.2000	.2041	.2084	
16	225	2250	.1867	.1911	.1956	.2000	.2045	.2089	.2134	.2178	.2223	
17	212	2118	.1983	.2031	.2078	.2125	.2172	.2220	.2267	.2314	.2361	
18	200	2000	.2100	.2150	.2200	.2250	.2300	.2350	.2400	.2450	.2500	
19	190	1895	.2217	.2270	.2322	.2375	.2428	.2481	.2534	.2586	.2639	
20	180	1800	.2333	.2389	.2445	.2500	.2556	.2611	.2667	.2723	.2778	
21	171	1714	.2450	.2508	.2567	.2625	.2684	.2742	.2800	.2859	.2917	
22	164	1636	.2567	.2628	.2689	.2750	.2811	.2873	.2934	.2995	.3056	
23	157	1565	.2683	.2747	.2811	.2875	.2939	.3003	.3067	.3131	.3195	
24	150	1500	.2800	.2867	.2934	.3000	.3067	.3134	.3200	.3267	.3334	
25	144	1440	.2917	.2986	.3056	.3125	.3195	.3264	.3334	.3403	.3473	
26	138	1384	.3033	.3106	.3178	.3250	.3323	.3395	.3467	.3539	.3612	
27	133	1333	.3150	.3225	.3300	.3375	.3450	.3525	.3600	.3676	.3751	
28	129	1285	.3267	.3345	.3422	.3500	.3578	.3656	.3734	.3712	.3889	
29	124	1241	.3383	.3465	.3545	.3625	.3706	.3787	.3867	.3848	.4028	
30	120	1200	.3500	.3584	.3667	.3750	.3834	.3917	.4001	.4084	.4167	
31	116	1161	.3617	.3703	.3789	.3875	.3961	.4048	.4134	.4220	.4306	
32	112	1125	.3733	.3822	.3911	.4000	.4089	.4178	.4267	.4356	.4445	
33	109	1091	.3850	.3942	.4034	.4125	.4217	.4309	.4401	.4492	.4584	
34	106	1059	.3967	.4061	.4156	.4250	.4345	.4439	.4534	.4628	.4723	
35	103	1028	.4083	.4181	.4278	.4375	.4473	.4570	.4667	.4765	.4862	
36	100	1000	.4200	.4300	.4400	.4500	.4600	.4701	.4801	.4901	.5001	
37	97	973	.4317	.4420	.4523	.4625	.4728	.4831	.4934	.5037	.5140	
38	95	947	.4433	.4539	.4645	.4750	.4856	.4962	.5067	.5173	.5279	
39	92	923	.4550	.4659	.4767	.4875	.4984	.5092	.5201	.5309	.5417	
40	90	900	.4667	.4778	.4889	.5000	.5112	.5223	.5334	.5445	.5556	
41	88	878	.4783	.4897	.5011	.5125	.5239	.5353	.5467	.5581	.5695	
42	86	857	.4900	.5017	.5134	.5250	.5367	.5484	.5601	.5717	.5834	
43	84	837	.5017	.5136	.5256	.5375	.5495	.5615	.5734	.5854	.5973	
44	82	818	.5133	.5256	.5378	.5500	.5623	.5745	.5867	.5990	.6112	
45	80	800	.5250	.5375	.5500	.5625	.5751	.5876	.6001	.6126	.6251	
46	78	782	.5367	.5495	.5623	.5750	.5878	.6006	.6134	.6262	.6390	
47	76	766	.5483	.5614	.5745	.5875	.6006	.6137	.6267	.6398	.6529	
48	75	750	.5600	.5734	.5867	.6000	.6134	.6267	.6401	.6534	.6668	
49	73	735	.5717	.5853	.5989	.6125	.6262	.6398	.6534	.6660	.6807	
50	72	720	.5834	.5973	.6112	.6250	.6390	.6529	.6668	.6806	.6946	
51	71	706	.5950	.6092	.6234	.6375	.6517	.6659	.6801	.6943	.7084	
52	69	692	.6067	.6211	.6356	.6500	.6645	.6790	.6934	.7079	.7223	
53	68	679	.6184	.6331	.6478	.6625	.6773	.6920	.7068	.7215	.7362	
54	67	666	.6300	.6450	.6600	.6750	.6901	.7051	.7201	.7351	.7501	
55	65	654	.6417	.6570	.6723	.6875	.7028	.7181	.7334	.7487	.7640	
56	64	642	.6534	.6689	.6845	.7000	.7156	.7312	.7468	.7623	.7779	
57	63	631	.6650	.6809	.6967	.7125	.7284	.7442	.7601	.7759	.7918	
58	62	621	.6767	.6928	.7089	.7250	.7412	.7573	.7734	.7896	.8057	
59	61	610	.6884	.7048	.7212	.7375	.7540	.7704	.7868	.8032	.8196	
60	60	600	.7000	.7167	.7334	.7500	.7667	.7834	.8001	.8168	.8335	

PIECE WORK RATE-SETTING TABLE

TEN HOURS A DAY

Minutes to do One Piece	No. of Pieces in Ten Hours	AMOUNT PER DAY								
		1.50	1.60	1.70	1.75	1.80	1.90	2.00	2.10	2.25
		RATE PER 100 PIECES								
1	600	.25	.27	.28	.29	.30	.32	.33	.35	.38
2	300	.50	.53	.57	.58	.60	.63	.67	.70	.75
3	200	.75	.80	.85	.87	.90	.95	1.00	1.05	1.12
4	150	1.00	1.07	1.13	1.17	1.20	1.27	1.33	1.40	1.50
5	120	1.25	1.33	1.42	1.46	1.50	1.58	1.67	1.75	1.88
6	100	1.50	1.60	1.70	1.75	1.80	1.90	2.00	2.10	2.25
7	85.7	1.75	1.87	1.98	2.04	2.10	2.22	2.33	2.45	2.63
8	75	2.00	2.13	2.27	2.33	2.40	2.53	2.67	2.80	3.00
9	66.7	2.25	2.40	2.55	2.62	2.70	2.85	3.00	3.15	3.38
10	60	2.50	2.67	2.83	2.92	3.00	3.17	3.33	3.50	3.75
11	54.5	2.75	2.93	3.12	3.21	3.30	3.48	3.67	3.85	4.13
12	50	3.00	3.20	3.40	3.50	3.60	3.80	4.00	4.20	4.50
13	46.1	3.25	3.47	3.68	3.79	3.90	4.12	4.33	4.55	4.88
14	42.8	3.50	3.73	3.97	4.08	4.20	4.43	4.67	4.90	5.25
15	40	3.75	4.00	4.25	4.37	4.50	4.75	5.00	5.25	5.63
16	37.5	4.00	4.27	4.53	4.67	4.80	5.07	5.33	5.60	6.00
17	35.3	4.25	4.53	4.82	4.96	5.10	5.38	5.67	5.95	6.38
18	33.3	4.50	4.80	5.10	5.25	5.40	5.70	6.00	6.30	6.75
19	31.6	4.75	5.07	5.38	5.54	5.70	6.02	6.33	6.65	7.13
20	30	5.00	5.33	5.67	5.83	6.00	6.33	6.67	7.00	7.50
21	28.6	5.25	5.60	5.95	6.12	6.30	6.65	7.00	7.35	7.88
22	27.3	5.50	5.87	6.23	6.42	6.60	6.97	7.33	7.70	8.25
23	26.1	5.75	6.13	6.52	6.71	6.90	7.28	7.67	8.05	8.63
24	25	6.00	6.40	6.80	7.00	7.20	7.60	8.00	8.40	9.00
25	24	6.25	6.67	7.08	7.29	7.50	7.92	8.33	8.75	9.38
26	23.1	6.50	6.93	7.37	7.58	7.80	8.23	8.67	9.10	9.75
27	22.2	6.75	7.20	7.65	7.87	8.10	8.55	9.00	9.45	10.13
28	21.4	7.00	7.47	7.93	8.17	8.40	8.87	9.33	9.80	10.50
29	20.7	7.25	7.73	8.22	8.46	8.70	9.18	9.67	10.15	10.88
30	20	7.50	8.00	8.50	8.75	9.00	9.50	10.00	10.50	11.25
31	19.3	7.75	8.27	8.78	9.04	9.30	9.82	10.33	10.85	11.63
32	18.7	8.00	8.53	9.07	9.33	9.60	10.13	10.67	11.20	12.00
33	18.2	8.25	8.80	9.35	9.62	9.90	10.45	11.00	11.55	12.38
34	17.6	8.50	9.07	9.63	9.92	10.20	10.77	11.33	11.90	12.75
35	17.1	8.75	9.33	9.92	10.21	10.50	11.08	11.67	12.25	13.13
36	16.7	9.00	9.60	10.20	10.50	10.80	11.40	12.00	12.60	13.50
37	16.2	9.25	9.87	10.48	10.79	11.10	11.72	12.33	12.95	13.88
38	15.8	9.50	10.13	10.76	11.08	11.40	12.03	12.67	13.30	14.25
39	15.4	9.75	10.40	11.05	11.37	11.70	12.35	13.00	13.65	14.63
40	15	10.00	10.67	11.33	11.67	12.00	12.67	13.33	14.00	15.00
41	14.6	10.25	10.93	11.62	11.96	12.30	12.98	13.67	14.35	15.38
42	14.3	10.50	11.20	11.90	12.25	12.60	13.30	14.00	14.70	15.75
43	14	10.75	11.47	12.19	12.54	12.90	13.62	14.33	15.05	16.13
44	13.6	11.00	11.73	12.47	12.83	13.20	13.93	14.67	15.40	16.50
45	13.3	11.25	12.00	12.75	13.12	13.50	14.25	15.00	15.75	16.88
46	13	11.50	12.27	13.04	13.42	13.80	14.57	15.33	16.10	17.25
47	12.8	11.75	12.53	13.32	13.71	14.10	14.88	15.67	16.41	17.63
48	12.5	12.00	12.80	13.60	14.00	14.40	15.20	16.00	16.80	18.00
49	12.2	12.25	13.07	13.89	14.29	14.70	15.52	16.33	17.15	18.38
50	12	12.50	13.34	14.17	14.58	15.00	15.83	16.67	17.50	18.75
51	11.8	12.75	13.60	14.45	14.87	15.30	16.15	17.00	17.85	19.13
52	11.5	13.00	13.87	14.74	15.17	15.60	16.46	17.33	18.20	19.50
53	11.3	13.25	14.14	15.02	15.46	15.90	16.78	17.67	18.55	19.88
54	11.1	13.50	14.40	15.30	15.75	16.20	17.10	18.00	18.90	20.25
55	10.9	13.75	14.67	15.59	16.04	16.50	17.42	18.33	19.25	20.63
56	10.7	14.00	14.94	15.87	16.33	16.80	17.73	18.67	19.60	21.00
57	10.5	14.25	15.20	16.15	16.62	17.10	18.05	19.00	19.95	21.38
58	10.3	14.50	15.47	16.44	16.92	17.40	18.37	19.33	20.30	21.75
59	10.2	14.75	15.74	16.72	17.21	17.70	18.68	19.67	20.65	22.13
60	10	15.00	16.00	17.00	17.50	18.00	19.00	20.00	21.00	22.50

PIECE WORK RATE-SETTING TABLE

TEN HOURS A DAY

Minutes to do One Piece	No. of Pieces in Ten Hours	AMOUNT PER DAY								
		2.40	2.50	2.60	2.75	2.80	2.90	3.00	3.10	3.20
		RATE PER 100 PIECES								
1	600	.40	.42	.43	.46	.47	.48	.50	.52	.53
2	300	.80	.83	.87	.92	.93	.97	1.00	1.03	1.07
3	200	1.20	1.25	1.30	1.37	1.40	1.45	1.50	1.55	1.60
4	150	1.60	1.67	1.73	1.83	1.87	1.93	2.00	2.07	2.13
5	120	2.00	2.08	2.17	2.29	2.33	2.42	2.50	2.58	2.67
6	100	2.40	2.50	2.60	2.75	2.80	2.90	3.00	3.10	3.20
7	85.7	2.80	2.92	3.03	3.21	3.27	3.38	3.50	3.62	3.73
8	75	3.20	3.33	3.47	3.67	3.73	3.87	4.00	4.13	4.27
9	66.7	3.60	3.75	3.90	4.12	4.20	4.35	4.50	4.65	4.80
10	60	4.00	4.17	4.33	4.58	4.67	4.83	5.00	5.17	5.33
11	54.5	4.40	4.58	4.77	5.04	5.13	5.32	5.50	5.68	5.87
12	50	4.80	5.00	5.20	5.50	5.60	5.80	6.00	6.20	6.40
13	46.1	5.20	5.42	5.63	5.96	6.07	6.28	6.50	6.72	6.93
14	42.8	5.60	5.83	6.07	6.42	6.53	6.77	7.00	7.23	7.47
15	40	6.00	6.25	6.50	6.87	7.00	7.25	7.50	7.75	8.00
16	37.5	6.40	6.67	6.93	7.33	7.47	7.73	8.00	8.27	8.53
17	35.3	6.80	7.08	7.37	7.79	7.93	8.22	8.50	8.78	9.07
18	33.3	7.20	7.50	7.80	8.25	8.40	8.70	9.00	9.30	9.60
19	31.6	7.60	7.92	8.23	8.71	8.87	9.18	9.50	9.82	10.13
20	30	8.00	8.33	8.67	9.17	9.33	9.67	10.00	10.33	10.67
21	28.6	8.40	8.75	9.10	9.62	9.80	10.15	10.50	10.85	11.20
22	27.3	8.80	9.17	9.53	10.08	10.27	10.63	11.00	11.37	11.73
23	26.1	9.20	9.58	9.97	10.54	10.73	11.12	11.50	11.88	12.27
24	25	9.60	10.00	10.40	11.00	11.20	11.60	12.00	12.40	12.80
25	24	10.00	10.42	10.83	11.46	11.67	12.08	12.50	12.92	13.33
26	23.1	10.40	10.83	11.27	11.92	12.13	12.57	13.00	13.43	13.87
27	22.2	10.80	11.25	11.70	12.37	12.60	13.05	13.50	13.95	14.40
28	21.4	11.20	11.66	12.13	12.83	13.06	13.53	14.00	14.47	14.93
29	20.7	11.60	12.08	12.57	13.29	13.53	14.02	14.50	14.98	15.47
30	20	12.00	12.50	13.00	13.75	14.00	14.50	15.00	15.50	16.00
31	19.3	12.40	12.91	13.43	14.21	14.46	14.98	15.50	16.02	16.53
32	18.7	12.80	13.33	13.87	14.67	14.93	15.47	16.00	16.53	17.07
33	18.2	13.20	13.75	14.30	15.12	15.40	15.95	16.50	17.05	17.60
34	17.6	13.60	14.16	14.73	15.58	15.86	16.43	17.00	17.57	18.13
35	17.1	14.00	14.58	15.17	16.04	16.33	16.92	17.50	18.08	18.67
36	16.7	14.40	15.00	15.60	16.50	16.80	17.40	18.00	18.60	19.20
37	16.2	14.80	15.41	16.03	16.96	17.26	17.88	18.50	19.12	19.73
38	15.8	15.20	15.83	16.47	17.42	17.73	18.37	19.00	19.63	20.27
39	15.4	15.60	16.25	16.90	17.87	18.20	18.85	19.50	20.15	20.80
40	15	16.00	16.66	17.33	18.33	18.66	19.33	20.00	20.67	21.33
41	14.6	16.40	17.08	17.77	18.79	19.13	19.82	20.50	21.18	21.87
42	14.3	16.80	17.50	18.20	19.25	19.60	20.30	21.00	21.70	22.40
43	14	17.20	17.91	18.63	19.71	20.06	20.78	21.50	22.22	22.93
44	13.6	17.60	18.33	19.07	20.17	20.53	21.27	22.00	22.73	23.47
45	13.3	18.00	18.75	19.50	20.62	21.00	21.75	22.50	23.25	24.00
46	13	18.40	19.16	19.93	21.08	21.46	22.23	23.00	23.77	24.53
47	12.8	18.80	19.58	20.37	21.54	21.93	22.72	23.50	24.28	25.07
48	12.5	19.20	20.00	20.80	22.00	22.40	23.20	24.00	24.80	25.60
49	12.2	19.60	20.41	21.23	22.46	22.86	23.68	24.50	25.32	26.13
50	12	20.00	20.83	21.67	22.92	23.33	24.17	25.00	25.84	26.67
51	11.8	20.40	21.25	22.10	23.37	23.80	24.65	25.50	26.35	27.20
52	11.5	20.80	21.66	22.53	23.83	24.26	25.13	26.00	26.87	27.73
53	11.3	21.20	22.08	22.96	24.29	24.73	25.61	26.50	27.39	28.26
54	11.1	21.60	22.50	23.40	24.75	25.20	26.10	27.00	27.90	28.80
55	10.9	22.00	22.91	23.83	25.21	25.66	26.58	27.50	28.42	29.33
56	10.7	22.40	23.33	24.26	25.66	26.13	27.06	28.00	28.94	29.86
57	10.5	22.80	23.75	24.70	26.12	26.60	27.55	28.50	29.45	30.40
58	10.3	23.20	24.16	25.13	26.58	27.06	28.03	29.00	29.97	30.93
59	10.2	23.60	24.58	25.56	27.04	27.53	28.51	29.50	30.49	31.47
60	10	24.00	25.00	26.00	27.50	28.00	29.00	30.00	31.00	32.00



PIECE WORK RATE-SETTING TABLE

TEN HOURS A DAY

Minutes to do One Piece	No. of Pieces in Ten Hours	AMOUNT PER DAY								
		3.30	3.40	3.50	3.60	3.70	3.80	3.90	4.00	4.10
		RATE PER 100 PIECES								
1	600	.55	.57	.58	.60	.62	.63	.65	.67	.68
2	300	1.10	1.13	1.17	1.20	1.23	1.27	1.30	1.33	1.37
3	200	1.65	1.70	1.75	1.80	1.85	1.90	1.95	2.00	2.05
4	150	2.20	2.27	2.33	2.40	2.47	2.53	2.60	2.67	2.73
5	120	2.75	2.83	2.92	3.00	3.08	3.17	3.25	3.33	3.42
6	100	3.30	3.40	3.50	3.60	3.70	3.80	3.90	4.00	4.10
7	85.7	3.85	3.97	4.08	4.20	4.32	4.43	4.55	4.67	4.78
8	75	4.40	4.53	4.67	4.80	4.93	5.07	5.20	5.33	5.47
9	66.7	4.95	5.10	5.25	5.40	5.55	5.70	5.85	6.00	6.15
10	60	5.50	5.67	5.83	6.00	6.17	6.33	6.50	6.67	6.83
11	54.5	6.05	6.23	6.42	6.60	6.78	6.97	7.15	7.33	7.52
12	50	6.60	6.80	7.00	7.20	7.40	7.60	7.80	8.00	8.20
13	46.1	7.15	7.37	7.58	7.80	8.02	8.23	8.45	8.67	8.88
14	42.8	7.70	7.93	8.17	8.40	8.63	8.87	9.10	9.33	9.57
15	40	8.25	8.50	8.75	9.00	9.25	9.50	9.75	10.00	10.25
16	37.5	8.80	9.07	9.33	9.60	9.87	10.13	10.40	10.67	10.93
17	35.3	9.35	9.63	9.92	10.20	10.48	10.77	11.05	11.33	11.62
18	33.3	9.90	10.20	10.50	10.80	11.10	11.40	11.70	12.00	12.30
19	31.6	10.45	10.77	11.08	11.40	11.72	12.03	12.35	12.67	12.98
20	30	11.00	11.33	11.67	12.00	12.33	12.67	13.00	13.33	13.67
21	28.6	11.55	11.90	12.25	12.60	12.95	13.30	13.65	14.00	14.35
22	27.3	12.10	12.47	12.83	13.20	13.57	13.93	14.30	14.67	15.03
23	26.1	12.65	13.03	13.42	13.80	14.18	14.57	14.95	15.33	15.72
24	25	13.20	13.60	14.00	14.40	14.80	15.20	15.60	16.00	16.40
25	24	13.75	14.17	14.58	15.00	15.42	15.83	16.25	16.67	17.08
26	23.1	14.30	14.73	15.17	15.60	16.03	16.47	16.90	17.33	17.77
27	22.2	14.85	15.30	15.75	16.20	16.65	17.10	17.55	18.00	18.45
28	21.4	15.40	15.86	16.33	16.80	17.26	17.73	18.20	18.67	19.13
29	20.7	15.95	16.43	16.92	17.40	17.88	18.37	18.85	19.33	19.82
30	20	16.50	17.00	17.50	18.00	18.50	19.00	19.50	20.00	20.50
31	19.3	17.05	17.56	18.08	18.60	19.11	19.63	20.15	20.67	21.18
32	18.7	17.60	18.13	18.67	19.20	19.73	20.27	20.80	21.33	21.87
33	18.2	18.15	18.70	19.25	19.80	20.35	20.90	21.45	22.00	22.55
34	17.6	18.70	19.26	19.83	20.40	20.96	21.53	22.10	22.67	23.23
35	17.1	19.25	19.83	20.42	21.00	21.58	22.17	22.75	23.33	23.92
36	16.7	19.80	20.40	21.00	21.60	22.20	22.80	23.40	24.00	24.60
37	16.2	20.35	20.96	21.58	22.20	22.81	23.43	24.05	24.67	25.28
38	15.8	20.90	21.53	22.17	22.80	23.43	24.07	24.70	25.33	25.97
39	15.4	21.45	22.10	22.75	23.40	24.05	24.70	25.35	26.00	26.65
40	15	22.00	22.66	23.33	24.00	24.66	25.33	26.00	26.67	27.33
41	14.6	22.55	23.23	23.92	24.60	25.28	25.97	26.65	27.33	28.02
42	14.3	23.10	23.80	24.50	25.20	25.90	26.60	27.30	28.00	28.70
43	14	23.65	24.36	25.08	25.80	26.51	27.23	27.95	28.67	29.38
44	13.6	24.20	24.93	25.67	26.40	27.13	27.87	28.60	29.33	30.07
45	13.3	24.75	25.50	26.25	27.00	27.75	28.50	29.25	30.00	30.75
46	13	25.30	26.06	26.83	27.60	28.36	29.13	29.90	30.67	31.43
47	12.8	25.85	26.63	27.42	28.20	28.98	29.77	30.55	31.33	32.12
48	12.5	26.40	27.20	28.00	28.80	29.60	30.40	31.20	32.00	32.80
49	12.2	26.95	27.76	28.50	29.40	30.21	31.03	31.85	32.67	33.48
50	12	27.50	28.33	29.17	30.00	30.83	31.67	32.50	33.33	34.17
51	11.8	28.05	28.90	29.75	30.60	31.45	32.30	33.15	34.00	34.85
52	11.5	28.60	29.46	30.33	31.20	32.06	32.93	33.80	34.67	35.53
53	11.3	29.15	30.03	30.91	31.80	32.68	33.56	34.45	35.34	36.21
54	11.1	29.70	30.60	31.50	32.40	33.30	34.20	35.10	36.00	36.90
55	10.9	30.25	31.16	32.08	33.00	33.91	34.83	35.75	36.67	37.58
56	10.7	30.80	31.73	32.66	33.60	34.53	35.46	36.40	37.33	38.26
57	10.5	31.35	32.30	33.25	34.20	35.15	36.10	37.05	38.00	38.95
58	10.3	31.90	32.86	33.80	34.80	35.76	36.73	37.70	38.67	39.63
59	10.2	32.45	33.43	34.41	35.40	36.38	37.36	38.35	39.33	40.31
60	10	33.00	34.00	35.00	36.00	37.00	38.00	39.00	40.00	41.00

PIECE WORK RATE-SETTING TABLE

TEN HOURS A DAY

Minutes to do One Piece	No. of Pieces in Ten Hours	AMOUNT PER DAY								
		4.20	4.30	4.40	4.50	4.60	4.70	4.80	4.90	5.00
		RATE PER 100 PIECES								
1	600	.70	.72	.73	.75	.77	.78	.80	.82	.83
2	300	1.40	1.43	1.47	1.50	1.53	1.57	1.60	1.63	1.67
3	200	2.10	2.15	2.20	2.25	2.30	2.35	2.40	2.45	2.50
4	150	2.80	2.87	2.93	3.00	3.07	3.13	3.20	3.27	3.33
5	120	3.50	3.58	3.67	3.75	3.83	3.92	4.00	4.08	4.17
6	100	4.20	4.30	4.40	4.50	4.60	4.70	4.80	4.90	5.00
7	85.7	4.90	5.02	5.13	5.25	5.37	5.48	5.60	5.72	5.83
8	75	5.60	5.73	5.87	6.00	6.13	6.27	6.40	6.53	6.67
9	66.7	6.30	6.45	6.60	6.75	6.90	7.05	7.20	7.35	7.50
10	60	7.00	7.17	7.33	7.50	7.67	7.83	8.00	8.17	8.34
11	54.5	7.70	7.88	8.07	8.25	8.43	8.62	8.80	8.98	9.17
12	50	8.40	8.60	8.80	9.00	9.20	9.40	9.60	9.80	10.00
13	46.1	9.10	9.32	9.53	9.75	9.97	10.18	10.40	10.62	10.84
14	42.8	9.80	10.03	10.27	10.50	10.73	10.97	11.20	11.44	11.67
15	40	10.50	10.75	11.00	11.25	11.50	11.75	12.00	12.25	12.50
16	37.5	11.20	11.47	11.73	12.00	12.27	12.53	12.80	13.07	13.34
17	35.3	11.90	12.18	12.47	12.75	13.03	13.32	13.60	13.89	14.17
18	33.3	12.60	12.90	13.20	13.50	13.80	14.10	14.40	14.70	15.00
19	31.6	13.30	13.62	13.93	14.25	14.57	14.88	15.20	15.52	15.84
20	30	14.00	14.33	14.67	15.00	15.33	15.67	16.00	16.34	16.67
21	28.6	14.70	15.05	15.40	15.75	16.10	16.45	16.80	17.15	17.50
22	27.3	15.40	15.77	16.13	16.50	16.83	17.23	17.60	17.97	18.34
23	26.1	16.10	16.48	16.87	17.25	17.63	18.02	18.40	18.79	19.17
24	25	16.80	17.20	17.60	18.00	18.40	18.80	19.20	19.60	20.00
25	24	17.50	17.92	18.34	18.75	19.17	19.59	20.00	20.42	20.84
26	23.1	18.20	18.63	19.07	19.50	19.93	20.37	20.80	21.24	21.67
27	22.2	18.90	19.35	19.80	20.25	20.70	21.15	21.60	22.05	22.50
28	21.4	19.60	20.07	20.54	21.00	21.47	21.94	22.40	22.87	23.34
29	20.7	20.30	20.78	21.27	21.75	22.23	22.72	23.20	23.69	24.17
30	20	21.00	21.50	22.00	22.50	23.00	23.50	24.00	24.50	25.01
31	19.3	21.70	22.22	22.74	23.25	23.77	24.29	24.80	25.32	25.84
32	18.7	22.40	22.93	23.47	24.00	24.53	25.07	25.60	26.14	26.67
33	18.2	23.10	23.65	24.20	24.75	25.30	25.85	26.40	26.95	27.51
34	17.6	23.80	24.37	24.94	25.50	26.07	26.64	27.20	27.77	28.34
35	17.1	24.50	25.08	25.67	26.25	26.83	27.42	28.00	28.59	29.17
36	16.7	25.20	25.80	26.40	27.00	27.60	28.20	28.80	29.40	30.01
37	16.2	25.90	26.52	27.14	27.75	28.37	28.99	29.60	30.22	30.84
38	15.8	26.60	27.23	27.87	28.50	29.13	29.77	30.40	31.04	31.67
39	15.4	27.30	27.95	28.60	29.25	29.90	30.55	31.20	31.86	32.51
40	15	28.00	28.67	29.34	30.00	30.67	31.34	32.00	32.67	33.34
41	14.6	28.70	29.38	30.07	30.75	31.43	32.12	32.80	33.49	34.17
42	14.3	29.40	30.10	30.80	31.50	32.20	32.90	33.60	34.31	35.01
43	14	30.10	30.82	31.54	32.25	32.97	33.67	34.40	35.12	35.84
44	13.6	30.80	31.53	32.27	33.00	33.73	34.47	35.20	35.94	36.67
45	13.3	31.50	32.25	33.00	33.75	34.50	35.25	36.00	36.76	37.51
46	13	32.20	32.97	33.74	34.50	35.27	36.04	36.80	37.57	38.34
47	12.8	32.90	33.68	34.47	35.25	36.03	36.82	37.60	38.39	39.17
48	12.5	33.60	34.40	35.20	36.00	36.80	37.60	38.40	39.21	40.01
49	12.2	34.30	35.12	35.94	36.75	37.57	38.37	39.20	40.02	40.84
50	12	35.00	35.84	36.67	37.50	38.34	39.17	40.00	40.84	41.68
51	11.8	35.70	36.55	37.40	38.25	39.10	39.95	40.80	41.66	42.51
52	11.5	36.40	37.27	38.14	39.00	39.87	40.74	41.60	42.47	43.34
53	11.3	37.10	37.99	38.87	39.75	40.64	41.52	42.40	43.29	44.18
54	11.1	37.80	38.70	39.60	40.50	41.40	42.30	43.20	44.11	45.01
55	10.9	38.50	39.42	40.34	41.25	42.17	43.09	44.00	44.92	45.84
56	10.7	39.20	40.14	41.07	42.00	42.94	43.87	44.80	45.74	46.68
57	10.5	39.90	40.85	41.80	42.75	43.70	44.65	45.60	46.56	47.51
58	10.3	40.60	41.57	42.54	43.50	44.47	45.44	46.40	47.37	48.34
59	10.2	41.30	42.29	43.27	44.25	45.24	46.22	47.20	48.19	49.18
60	10	42.00	43.00	44.00	45.00	46.00	47.00	48.00	49.00	50.00

PIECE WORK RATE-SETTING TABLE

TEN HOURS A DAY

Hours to do One Piece	No. of Pieces in 10 Hours	AMOUNT PER DAY						
		1.50	1.60	1.75	1.80	1.90	2.00	2.10
		RATE PER 100 PIECES						
1	10	15.00	16.00	17.50	18.00	19.00	20.00	21.00
2	5	30.00	32.00	35.00	36.00	38.00	40.00	42.00
3	3 $\frac{1}{3}$	45.00	48.00	52.50	54.00	57.00	60.00	63.00
4	2 $\frac{1}{2}$	60.00	64.00	70.00	72.00	76.00	80.00	84.00
5	2	75.00	80.00	87.50	90.00	95.00	100.00	105.00
6	1 $\frac{2}{3}$	90.00	96.00	105.00	108.00	114.00	120.00	126.00
7	1 $\frac{3}{7}$	105.00	112.00	122.50	126.00	133.00	140.00	147.00
8	1 $\frac{1}{4}$	120.00	128.00	140.00	144.00	152.00	160.00	168.00
9	1 $\frac{1}{9}$	135.00	144.00	157.50	162.00	171.00	180.00	189.00
10	1	150.00	160.00	175.00	180.00	190.00	200.00	210.00
Hours to do One Piece	No. of Pieces in 10 Hours	AMOUNT PER DAY						
		2.25	2.40	2.50	2.60	2.75	2.80	2.90
		RATE PER 100 PIECES						
1	10	22.50	24.00	25.00	26.00	27.50	28.00	29.00
2	5	45.00	48.00	50.00	52.00	55.00	56.00	58.00
3	3 $\frac{1}{3}$	67.50	72.00	75.00	78.00	82.50	84.00	87.00
4	2 $\frac{1}{2}$	90.00	96.00	100.00	104.00	110.00	112.00	116.00
5	2	112.50	120.00	125.00	130.00	137.50	140.00	145.00
6	1 $\frac{2}{3}$	135.00	144.00	150.00	156.00	165.00	168.00	174.00
7	1 $\frac{3}{7}$	157.50	168.00	175.00	182.00	192.50	196.00	203.00
8	1 $\frac{1}{4}$	180.00	192.00	200.00	208.00	220.00	224.00	232.00
9	1 $\frac{1}{9}$	202.50	216.00	225.00	234.00	247.50	252.00	261.00
10	1	225.00	240.00	250.00	260.00	275.00	280.00	290.00
Hours to do One Piece	No. of Pieces in 10 Hours	AMOUNT PER DAY						
		3.00	3.10	3.20	3.30	3.40	3.50	3.60
		RATE PER 100 PIECES						
1	10	30.00	31.00	32.00	33.00	34.00	35.00	36.00
2	5	60.00	62.00	64.00	66.00	68.00	70.00	72.00
3	3 $\frac{1}{3}$	90.00	93.00	96.00	99.00	102.00	105.00	108.00
4	2 $\frac{1}{2}$	120.00	124.00	128.00	132.00	136.00	140.00	144.00
5	2	150.00	155.00	160.00	165.00	170.00	175.00	180.00
6	1 $\frac{2}{3}$	180.00	186.00	192.00	198.00	204.00	210.00	216.00
7	1 $\frac{3}{7}$	210.00	217.00	224.00	231.00	238.00	245.00	252.00
8	1 $\frac{1}{4}$	240.00	248.00	256.00	264.00	272.00	280.00	288.00
9	1 $\frac{1}{9}$	270.00	279.00	288.00	297.00	306.00	315.00	324.00
10	1	300.00	310.00	320.00	330.00	340.00	350.00	360.00
Hours to do One Piece	No. of Pieces in 10 Hours	AMOUNT PER DAY						
		3.70	3.80	3.90	4.00	4.10	4.20	4.30
		RATE PER 100 PIECES						
1	10	37.00	38.00	39.00	40.00	41.00	42.00	43.00
2	5	74.00	76.00	78.00	80.00	82.00	84.00	86.00
3	3 $\frac{1}{3}$	111.00	114.00	117.00	120.00	123.00	126.00	129.00
4	2 $\frac{1}{2}$	148.00	152.00	156.00	160.00	164.00	168.00	172.00
5	2	185.00	190.00	195.00	200.00	205.00	210.00	215.00
6	1 $\frac{2}{3}$	222.00	228.00	234.00	240.00	246.00	252.00	258.00
7	1 $\frac{3}{7}$	259.00	266.00	273.00	280.00	287.00	294.00	301.00
8	1 $\frac{1}{4}$	296.00	304.00	312.00	320.00	328.00	336.00	344.00
9	1 $\frac{1}{9}$	333.00	342.00	351.00	360.00	369.00	378.00	387.00
10	1	370.00	380.00	390.00	400.00	410.00	420.00	430.00
Hours to do One Piece	No. of Pieces in 10 Hours	AMOUNT PER DAY						
		4.40	4.50	4.60	4.70	4.80	4.90	5.00
		RATE PER 100 PIECES						
1	10	44.00	45.00	46.00	47.00	48.00	49.00	50.00
2	5	88.00	90.00	92.00	94.00	96.00	98.00	100.00
3	3 $\frac{1}{3}$	132.00	135.00	138.00	141.00	144.00	147.00	150.00
4	2 $\frac{1}{2}$	176.00	180.00	184.00	188.00	192.00	196.00	200.00
5	2	220.00	225.00	230.00	235.00	240.00	245.00	250.00
6	1 $\frac{2}{3}$	264.00	270.00	276.00	282.00	288.00	294.00	300.00
7	1 $\frac{3}{7}$	308.00	315.00	322.00	329.00	336.00	343.00	350.00
8	1 $\frac{1}{4}$	352.00	360.00	368.00	376.00	384.00	392.00	400.00
9	1 $\frac{1}{9}$	396.00	405.00	414.00	423.00	432.00	441.00	450.00
10	1	440.00	450.00	460.00	470.00	480.00	490.00	500.00

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